

AD-A237 394



**TECHNOLOGY INSERTION-ENGINEERING SERVICES
PROCESS CHARACTERIZATION
TASK ORDER NO. 1
(BLOCK II)**

**DATABASE DOCUMENTATION BOOK
BOOK 1 OF 2**

OC-ALC

MATPCB

**CONTRACT SUMMARY REPORT
11 SEPTEMBER 1989**

**CONTRACT NO. F33600-88-D-0567
CDRL SEQUENCE NO. B008**



MCDONNELL DOUGLAS

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1.0 IDENTIFICATION OF RCC AND GENERAL INFORMATION

OC-ALC, RCC, MATPCB is responsible for the overhaul and testing of Jet Engine Fuel Manifolds, Fuel Nozzles and various fuel and hydraulic pumps. The overhaul area is primarily located in contiguous shops in the south side of Building 3001. Leak and pressure testing is completed in Building 3108. The two work areas are linked via an overhead conveyer chain system, for transporting parts between shop areas. The total area of MATPCB covers approximately 29313 feet for production and 5993 feet for support.

1.1 MANIFOLDS

The sub-unit overhauling and servicing Manifolds is basically arranged according to the sequence of operations and are also basically in line. With the exception of required Manifold Welding (MATPIW) and Machine shop (MATPCM) operations, all overhaul and test operations are performed by MATPCB. Although laid out in an orderly manner, the area is cluttered with parts stacked on the floor or on mobile shelf racks, awaiting processing.

The work areas are normally small, with equipment and benches located in a somewhat cramped arrangement.

1.2 FUEL NOZZLES

The Fuel Nozzle overhaul area is the smallest of the MATPCB areas. It is located immediately adjacent to the Manifold area providing minimal transit distance and time. The work benches are somewhat cluttered because the area is small and close-quartered. The low smoke nozzle overhaul area is near the Manifold final assembly area.

1.3 FUEL PUMPS

The Fuel and hydraulic Pump sub-unit is arranged in an east/west orientation with activities located basically in-line.

Since there are many types of pumps overhauled, there is no assembly line arrangement. Except for cleaning, test and when applicable, machining, all overhaul activities are performed at a single work station. Work stations (Benches) have pump-unique fixtures attached to them. These work benches are not arranged in categories of pumps, but are scattered throughout the overhaul sub-unit area. The cleaning tank, on which work is performed by the overhaul mechanics, are co-located within the overhaul area. This reduces transit time. NDI on the pumps is also performed by NDI personnel dedicated within the sub-unit overhaul area.

1.4 MATPCB TEST AREA

The MATPCB test area is located in Building 3108 which is located adjacent to (west of) building 3001, at the southwest corner. Building 3108, used for test, has increased safety and fire suppression systems. These added safety precautions are needed because of the nature of the test operations including the use of high pressure Hydraulic fluids, and fuel. The MATPCB area of Building 3108 covers approximately 21,126 square feet. Both pumps and completed manifolds (with nozzles) are sent to and from the test area from the sub-units by way of a conveyer chain system. Pumps are placed in suspended trays (3 1/2 X 2 1/2') where as manifolds are suspended by two-hooks.

The test stations are widely scattered throughout Building 3108 and are interspersed with other RCC test stations. No family grouping apparently exist. The conveyer is slow but effective. It takes between 15 to 45 minutes for parts to be conveyed between one station and another. If not picked off the line on arrival it may take up to 1.5 hours to complete the loop. The only signal system used between stations is a phone line. It is used primarily for "Hot" items only. Otherwise both ends "clear the line" daily at the beginning of first shift.

2.1 FACILITY LAYOUT DRAWING

The most current Facility Layout Drawing available have been updated by MDMSC personnel and reflects current conditions as of June 5, 1989. Two sets of drawings have been included representing layouts in both Building 3001 and 3108. Bins and cabinets included in the drawings are used primarily for the storage of spare parts, holding areas and miscellaneous tools and technical books. *The facility layout drawings provided by the ALC are contained in the attached expanding file.*

2.2 EQUIPMENT

The Equipment used in MATPCB varies from common and specialized hand tools to integrated test stands. Most of the equipment is between five and twenty five years old. Besides routine preventative maintenance there is very little down time due to machine breakdowns. A detailed listing of major non-controlled and OC controlled equipment is detailed in the Equipment Profile section.

WORKFORCE

Linda Dowdy/MATPCB OC-ALC

June 1989

MATPCB has a stable workforce consisting of Direct and Indirect labor. The Direct Labor is comprised of 63 mechanics and the Indirect consist of 6 Supervisors. The following is a breakdown of the direct labor for MATPCB:

<u>SKILL CODE</u>	<u>SKILL LEVEL</u>	<u>QUANTITY</u>	<u>YEARS OF AVG. EXPERIENCE</u>
BP	WG-10	7	12-25
	WG-09	15	4-25
	WG-05	1	4
BI	WG-09	2	10-15
AP	WG-09	15	4-20
	WG-07	1	5
	WG-05	2	5-7
DP	WG-09	20	4-25

DEPARTMENT HEAD COUNT BY WORK CLASSIFICATION

Chief Foreman	WS8255-13	1
Foreman	WS8255-09	5
Pneudraulics Sys. Mech	WG8255-10	6
Work Inspector	WG8255-10	1
Pneudraulics Sys. Mech	WG8255-09	50
NDI	WG5439-09	2
Sandblaster	WG5427-07	1
Forklift Operator	WG5704-05	2
Parts & Tool Attendant	WG6905-05	1
		<hr/>
		69 Total

All supporting RCC's are in Building 3001 and 3108.

2.4 REPAIR WORK TECHNOLOGIES

The process technology in MATPCB consist primarily of testing and repair of Jet Engine Fuel Manifolds, Fuel Nozzles and pumps. Parts are inspected, tested for function and specification requirements and overhauled as required. Modifications are made to parts as required by tech order changes.

WORKLOAD VOLUME AND MIX

Workload in MATPCB consist of MISTR (Management of Items Subject to Repair), PDM (Programmed Depot Maintenance-Engine line assets) and temporary. The workload percent mix is as follows:

<u>MISTR</u>	<u>PDM</u>	<u>TEMPORARY</u>
45%	50%	5%

End item to be overhauled in MATPCB are:

1. Fuel Pumps
2. Fuel Nozzles
3. Fuel Manifolds

End items tested by MATPCB

1. Fuel Pumps
2. Fuel Nozzles
3. Fuel Manifolds
4. Regulators
5. Cylinder
6. Valves

Engine Usage

B-52
KC135
A-7 Navy & AF
F4
F106
F111
G141
F11
F16

2.6 MATERIAL HANDLING

In MATPCB Material Handling is accomplished mostly by hand. A conveyer is used between the overhaul and testing areas of MATPCB. parts are sent to and picked up from the overhaul mechanics work bench with the exception of one, two-stage fuel pump, parts are carried by hand to and from NDI located within MATPCB. The large pump is transported on a push cart. Manifold parts (80%) are received in quantities of 25 by a fork lift truck. The other 20% comes directly from the engine tear-down shop usually by mechanized cart.

2.7 STORAGE

1.

The storage of parts and spares are primarily located in bins near the maintenance work benches. There are no designated storage areas in Building 3108 parts are received for testing one at a time. If more than one part is received per test stand, then parts are put on the test stand work bench until they are tested.

2.8 PROCESS FLOW CHARTS

The Flow Charts which follow are representative of the overhaul/ test operations of various parts worked on by MATPCB. They are divided into Family Part Groups. For more detailed analysis refer to the appropriate PCN/WCD.

3001
ENGINE
LINE

SUPPLY

BACKSTOCK
IN
MATPCB

TO
MECHANIC

DISASSEMBLY

CLEAN

INSP

OVERHAUL

ATTACH
PAPER-
WORK

MATROC

TEST
SAT.
SAFETY
WIRE

SHIP

3108
TEST

FAIL
TEST

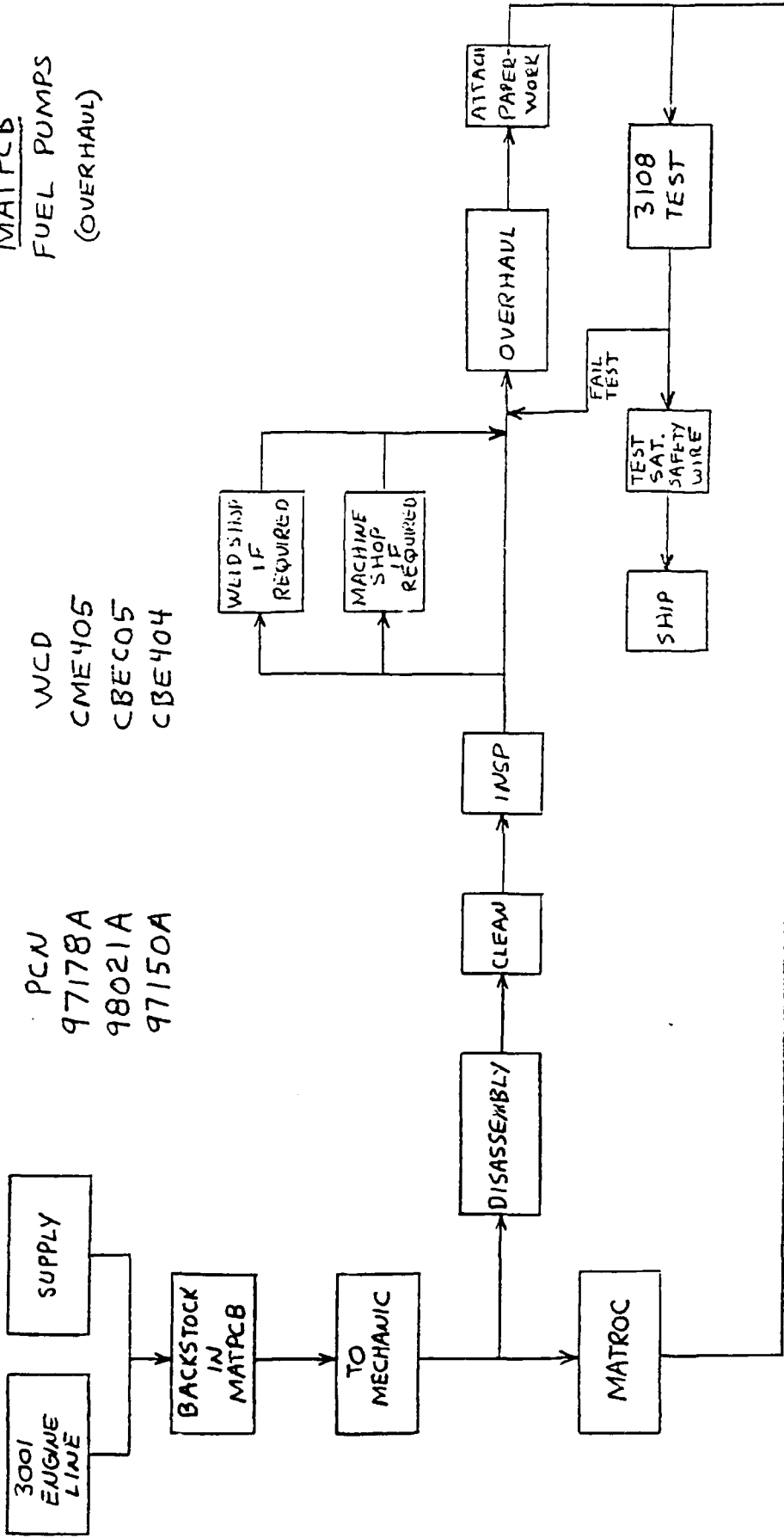
PCN
97178A
98021A
97150A

WCD
CME405
CBE405
CBE404

MATPCB
FUEL PUMPS
(OVERHAUL)

WELD SHOP
IF
REQUIRED

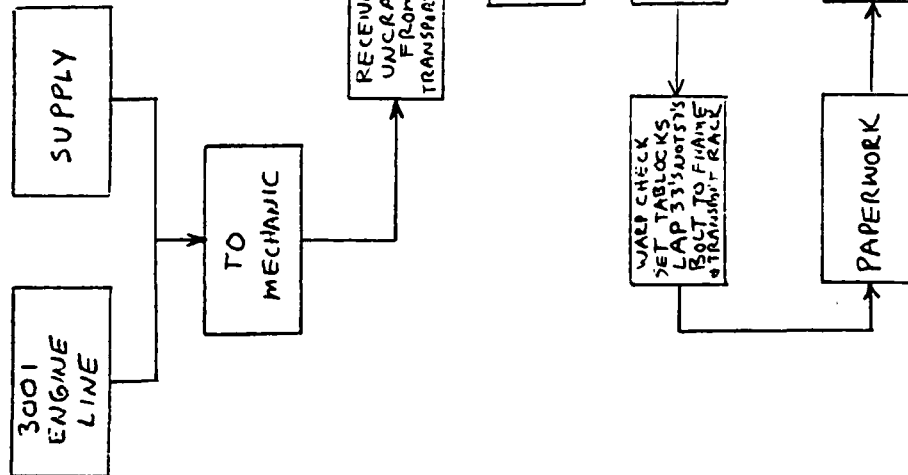
MACHINE
SHOP
IF
REQUIRED



MATPCB MANIFOLDS (OVERHAUL)

PCN'S FOR TF33 MANIFOLD
 98034A
 98042A
 78043A
 98057A
 WCD, CBEC04

PCN'S FOR TF57 MANIFOLDS
 49802A
 49806A
 49808A
 49810A
 WCD, CBE101



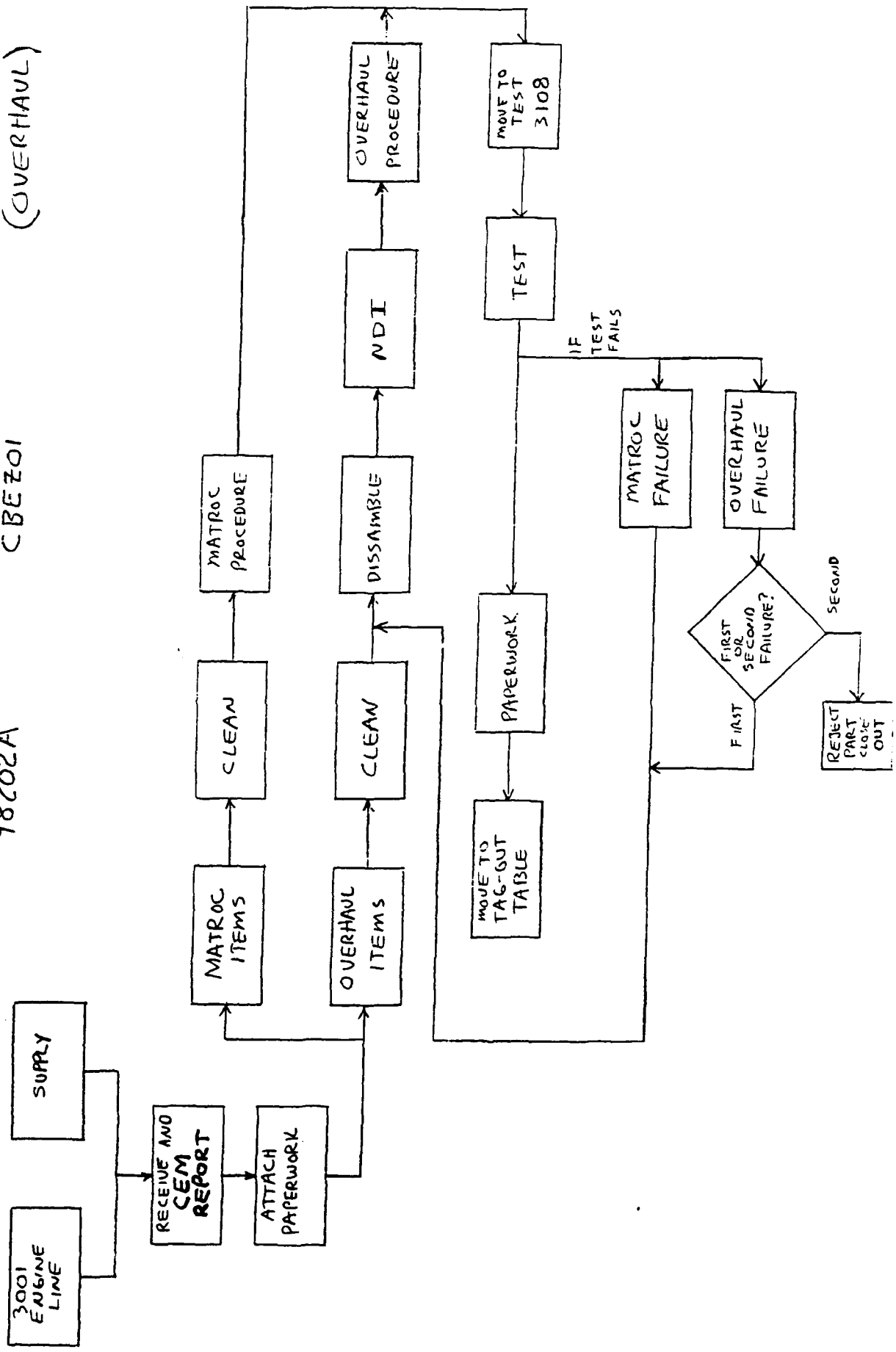
MOVE TO MATPCB MANIFOLD
 - MEASURE
 - WELD
 - MACHINE LUGS
 - 376LO
 - GRIND 57'S NOTCHES
 - CHEMTEST

MOVE TO MATPCB MANIFOLD
 - DRILL HOLES IF REQUIRED
 - INJECT & CURE SILICON
 - REMOVE SILICON
 - LAP SEAL SEATS

MATPCB
PUMP
(OVERHAUL)

WCD
CBEZ01

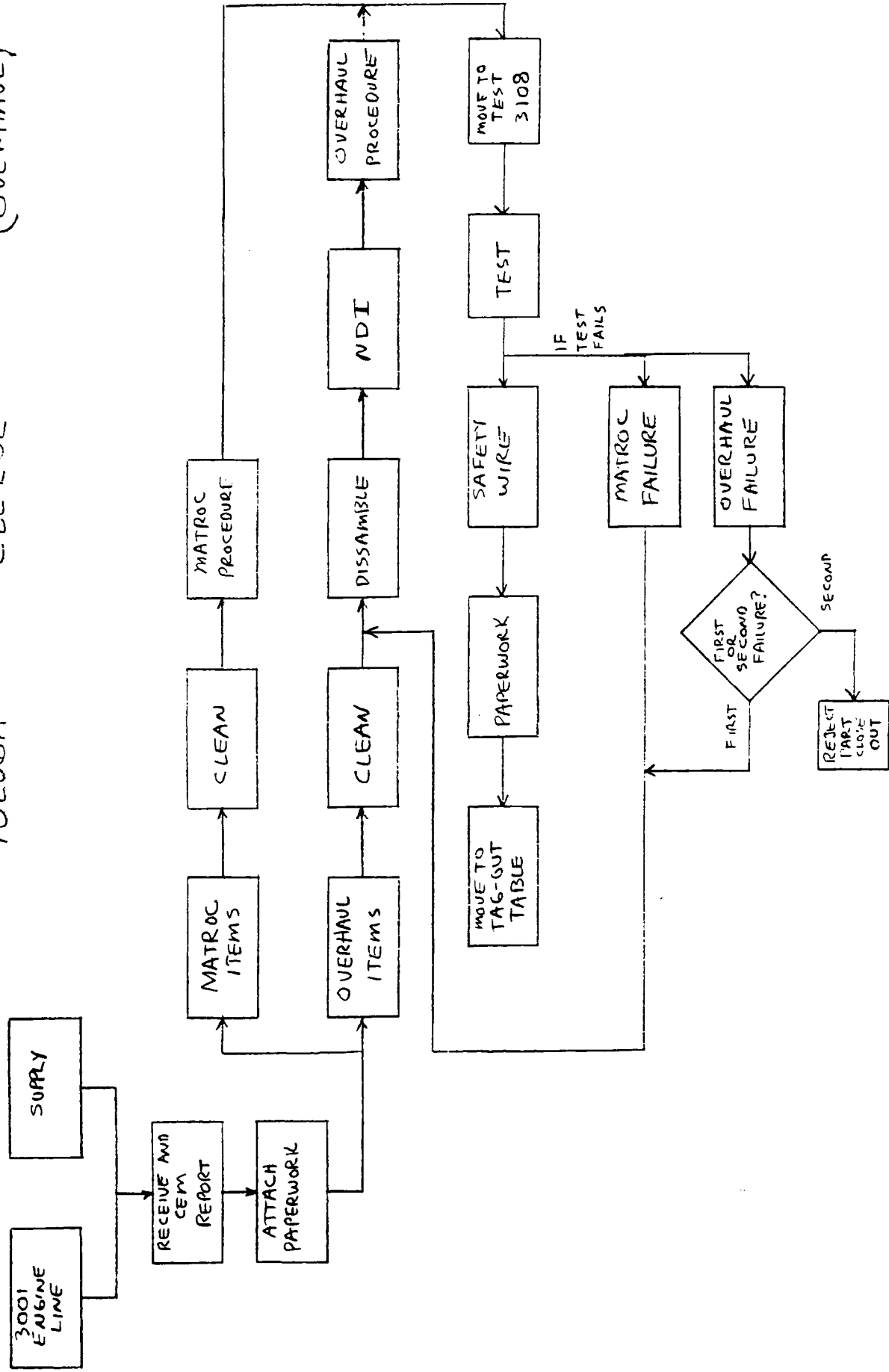
PCN
98202A



MATPCB
PUMP
(OVERHAUL)

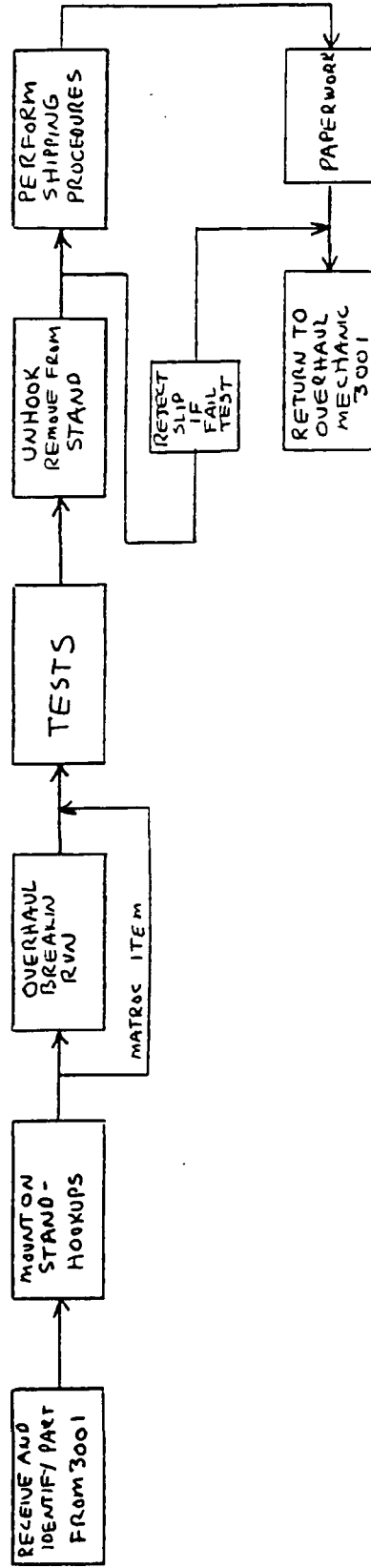
WCD
CBEZ02

PCN
98206A



MATPCB
FUEL PUMP
(TEST)

PCN WCD
98206A CBEZ94



PCN

38644A

50067A

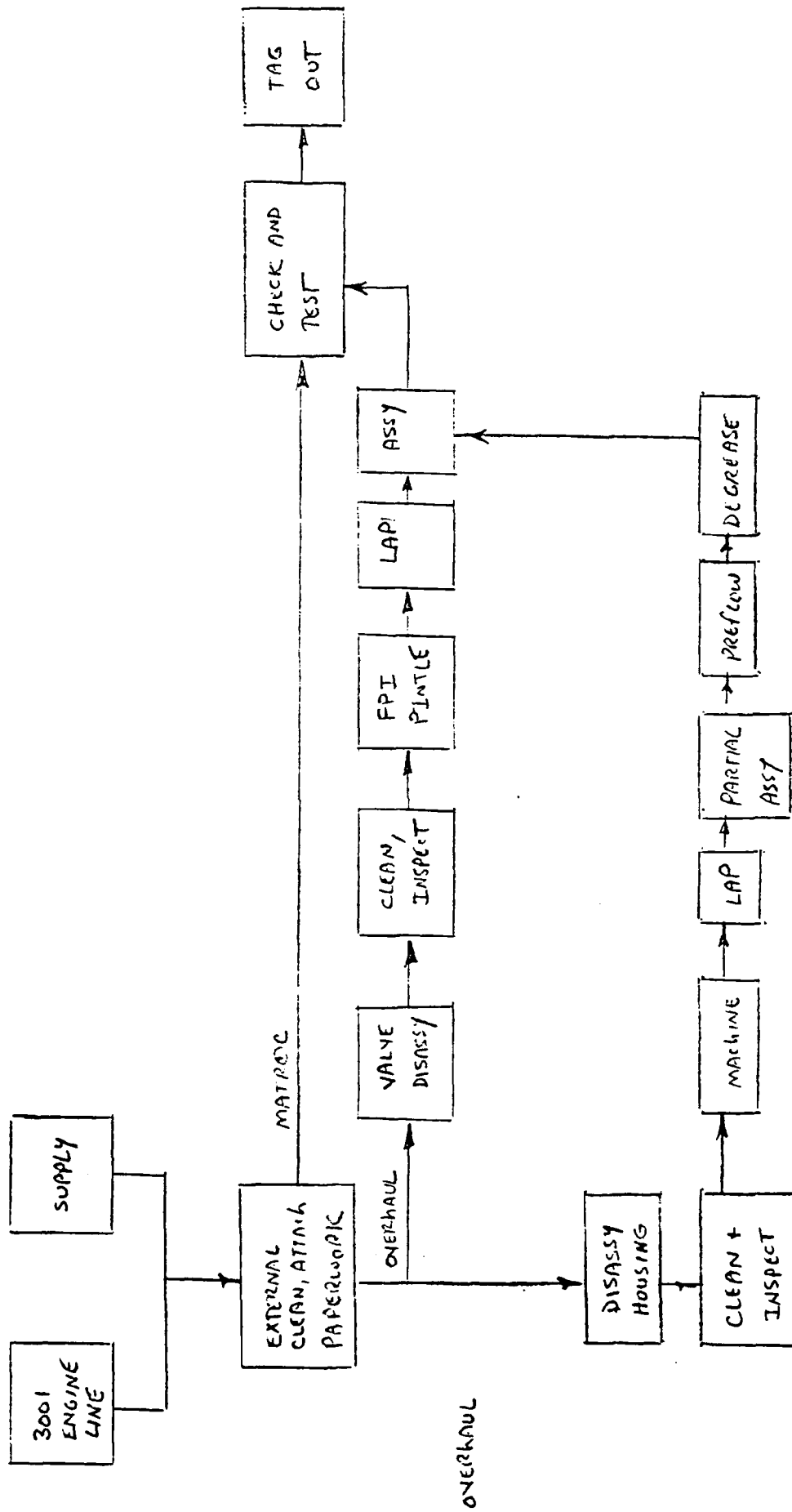
WCD

CBEM 19, CBEM 20

CBEM 29, CBEM 30, CBEM 31

MATPCB

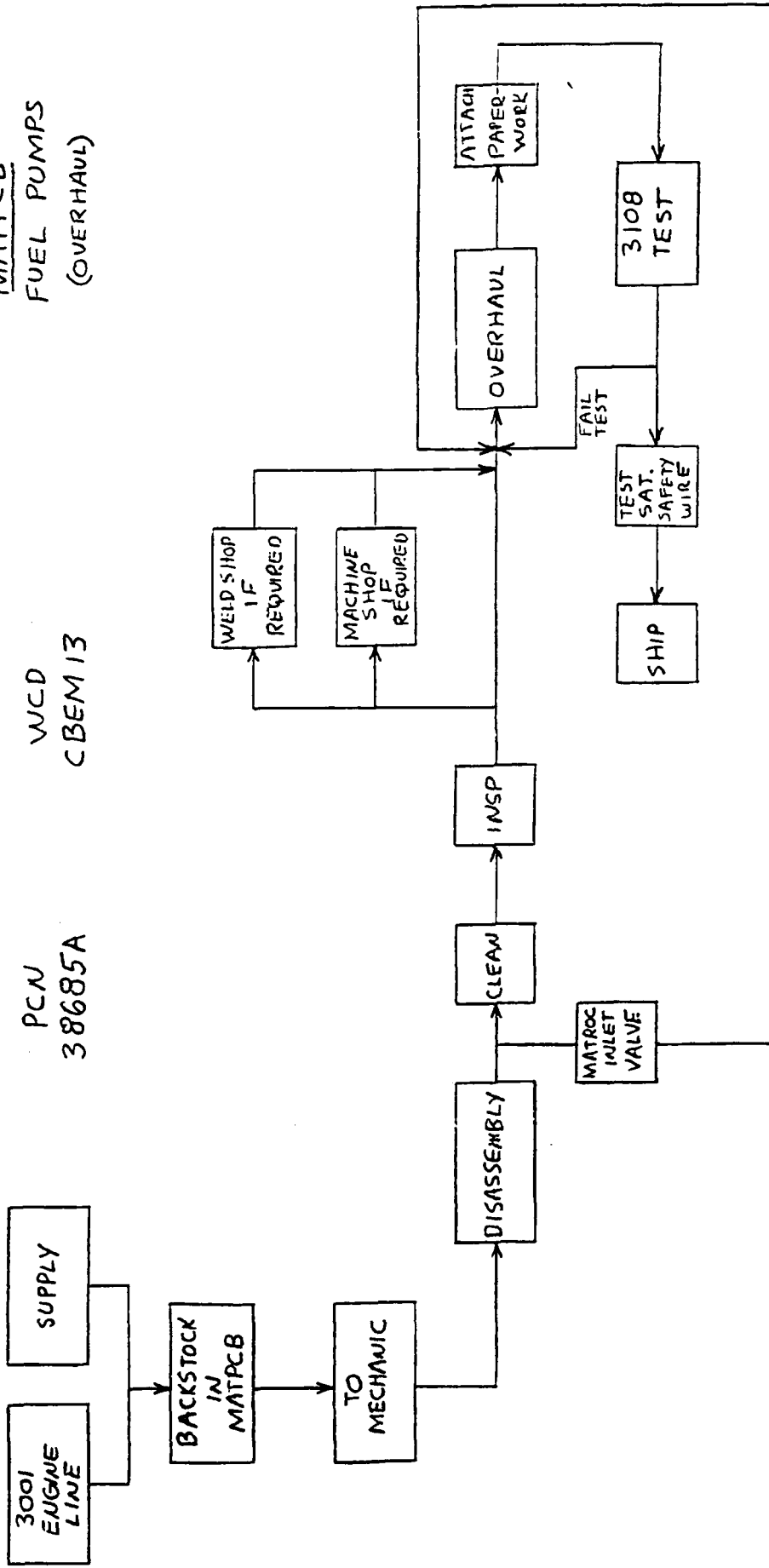
NOZZLES



MATPCB
FUEL PUMPS
(OVERHAUL)

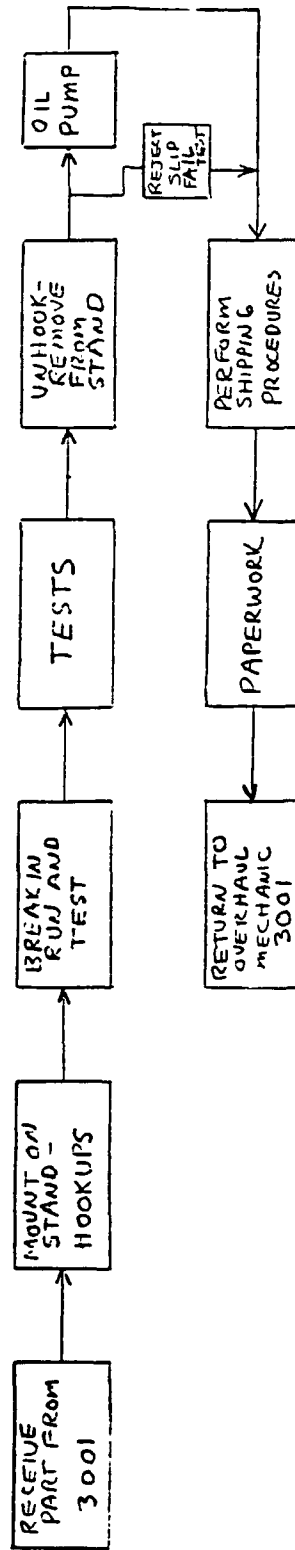
WCD
CBEM13

PCN
38685A



MATPCB
FUEL PUMPS
(TEST)

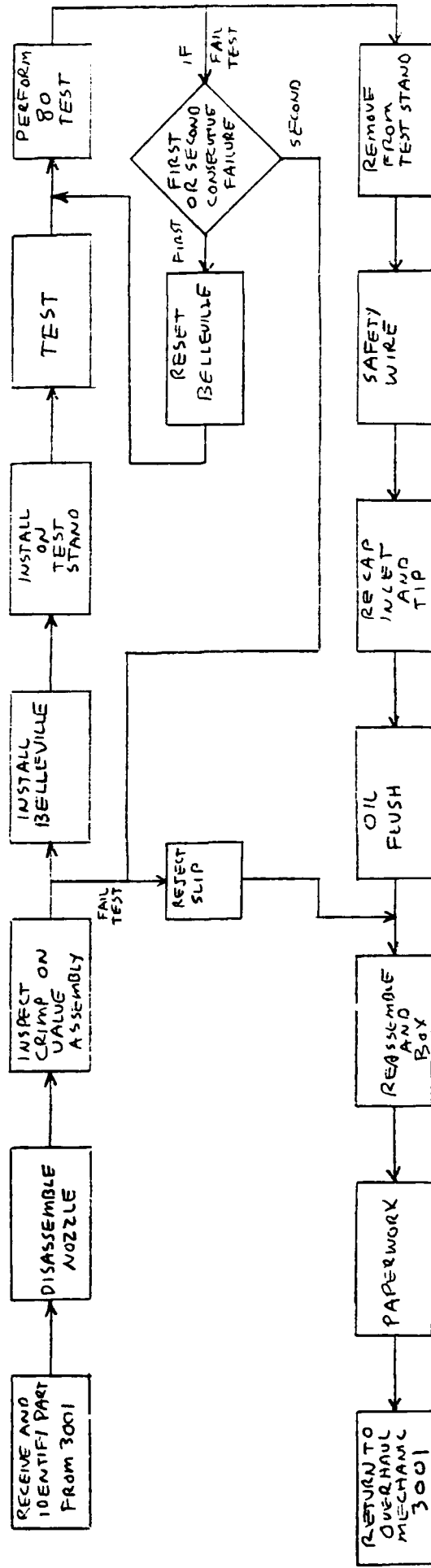
PCN	WCD
38685A	CBEM14
98202A	CBEZ01
96515A	CBEY07
96555A	CBEY17



MATPCB
NOZZLE
(TEST)

WCD
CMEM20
CBEM31 + CBEM30

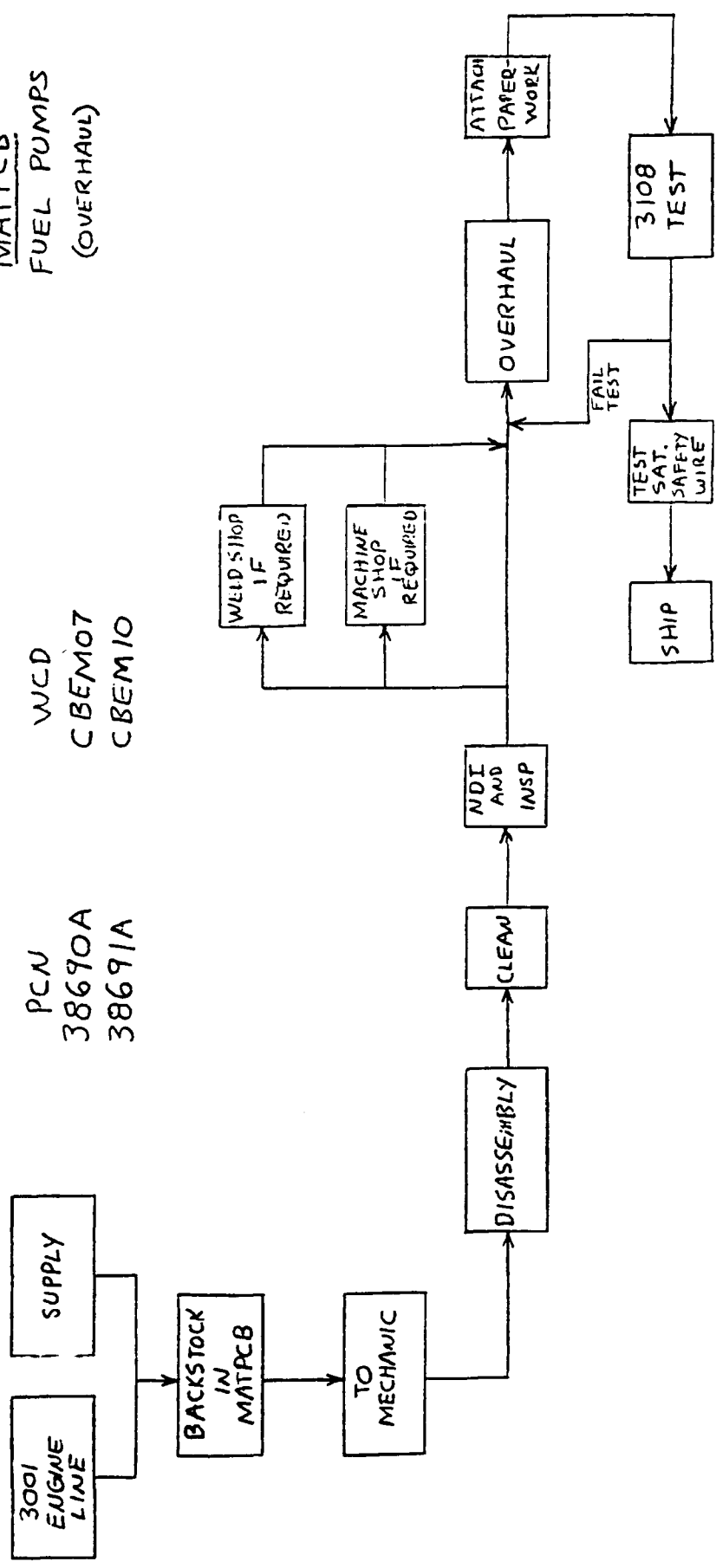
PCN
38644A
50067A



MATPCB
FUEL PUMPS
(OVERHAUL)

PCN
38690A
38691A

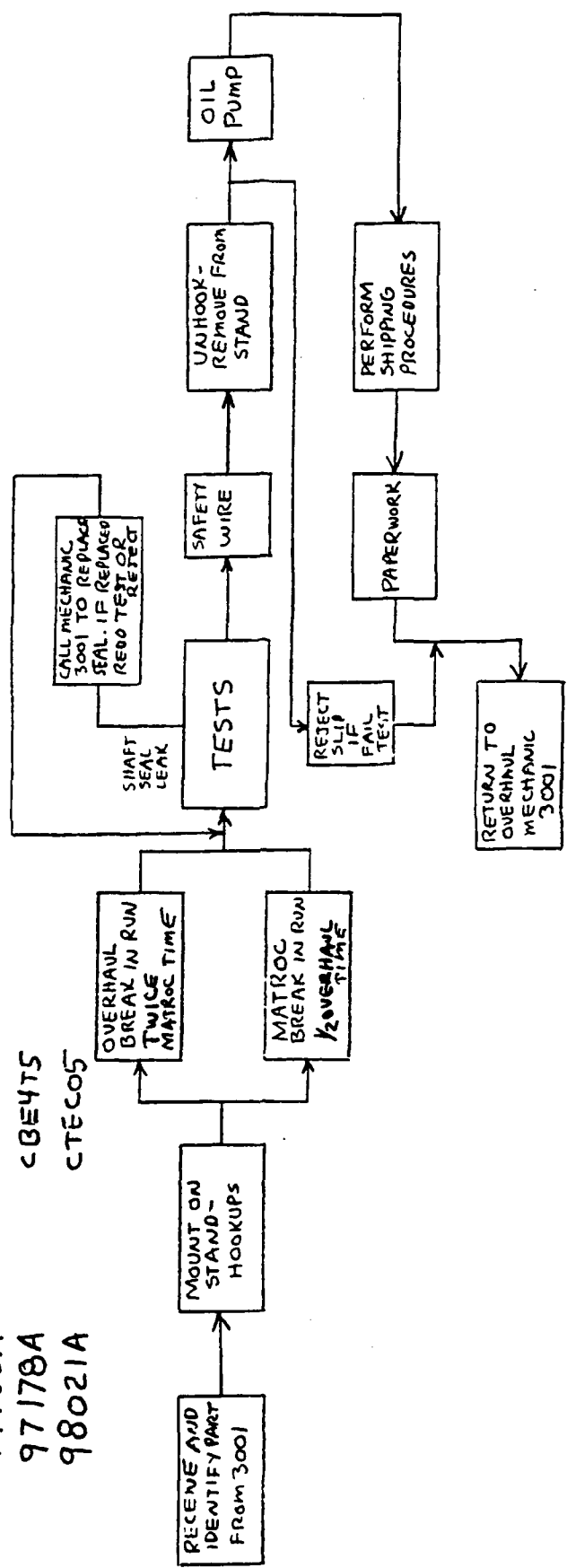
WCD
CBEM07
CBEM10



MATPCB FUEL PUMPS (TEST)

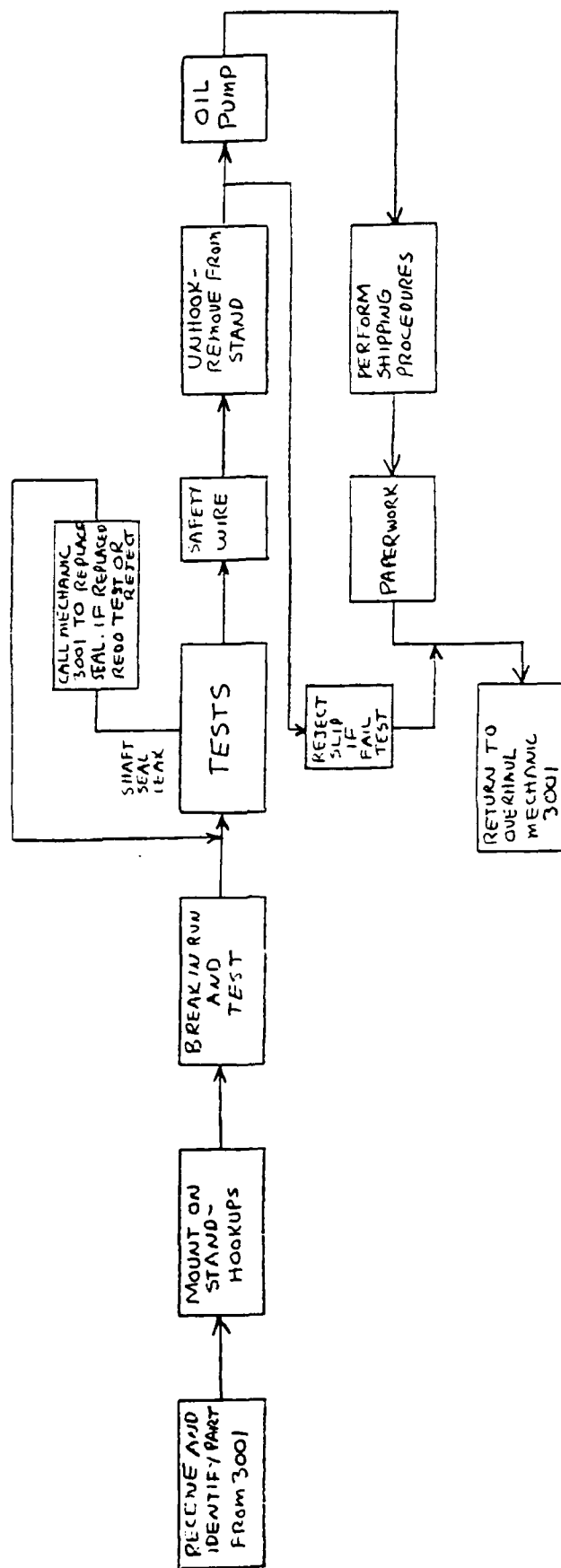
PCN
38690A
38691A
97150A
97178A
98021A

WCD
CBEM08
CBEM12
CBE474
CBE475
CTEC05



MATPCB
HYDRAULIC PUMP
(TEST)

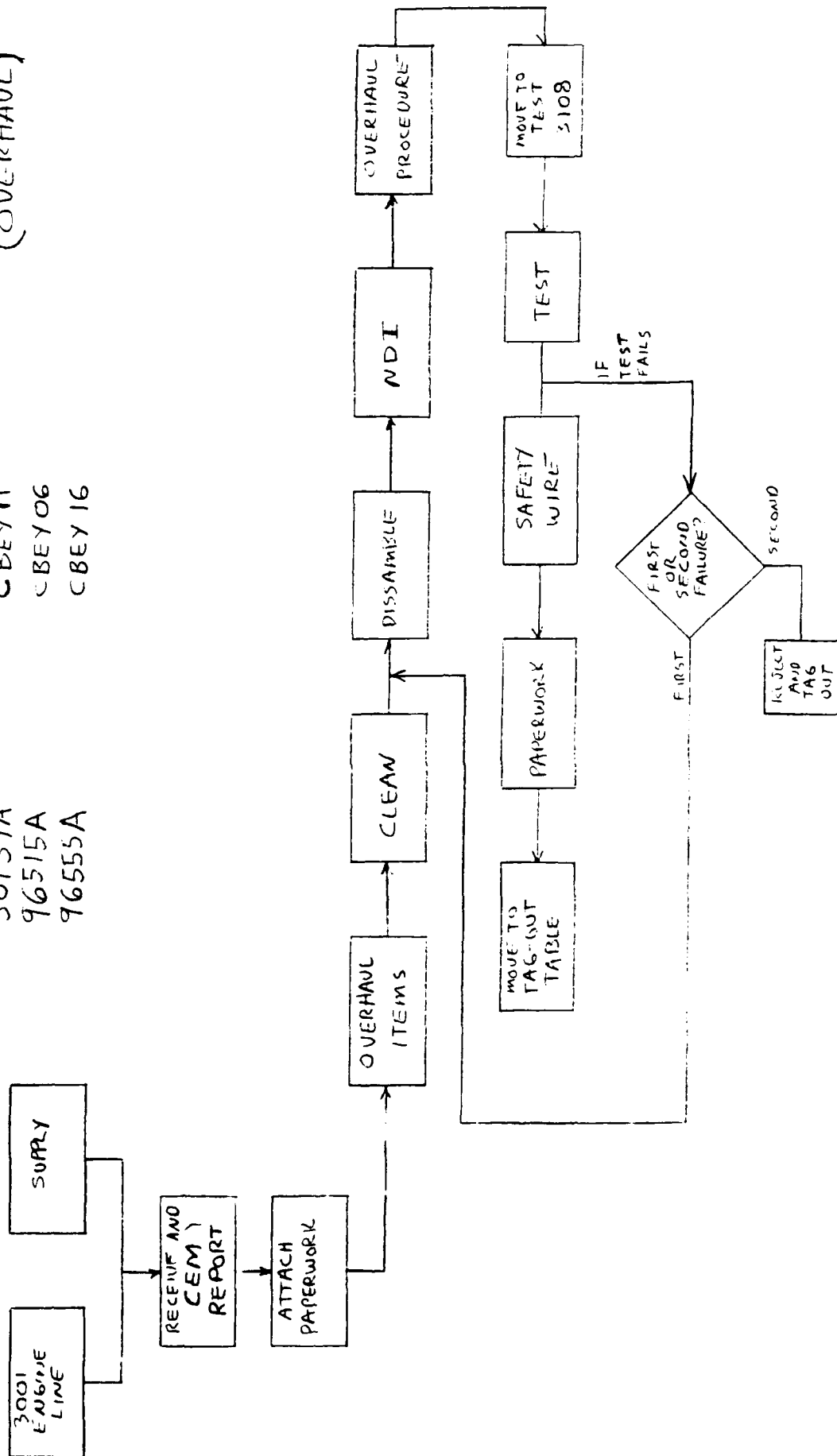
PCN 50134A
WCD
CREYIO



MATPCB
PUMP
(OVERHAUL)

WCD
CB EY 11
CB EY 06
CB EY 16

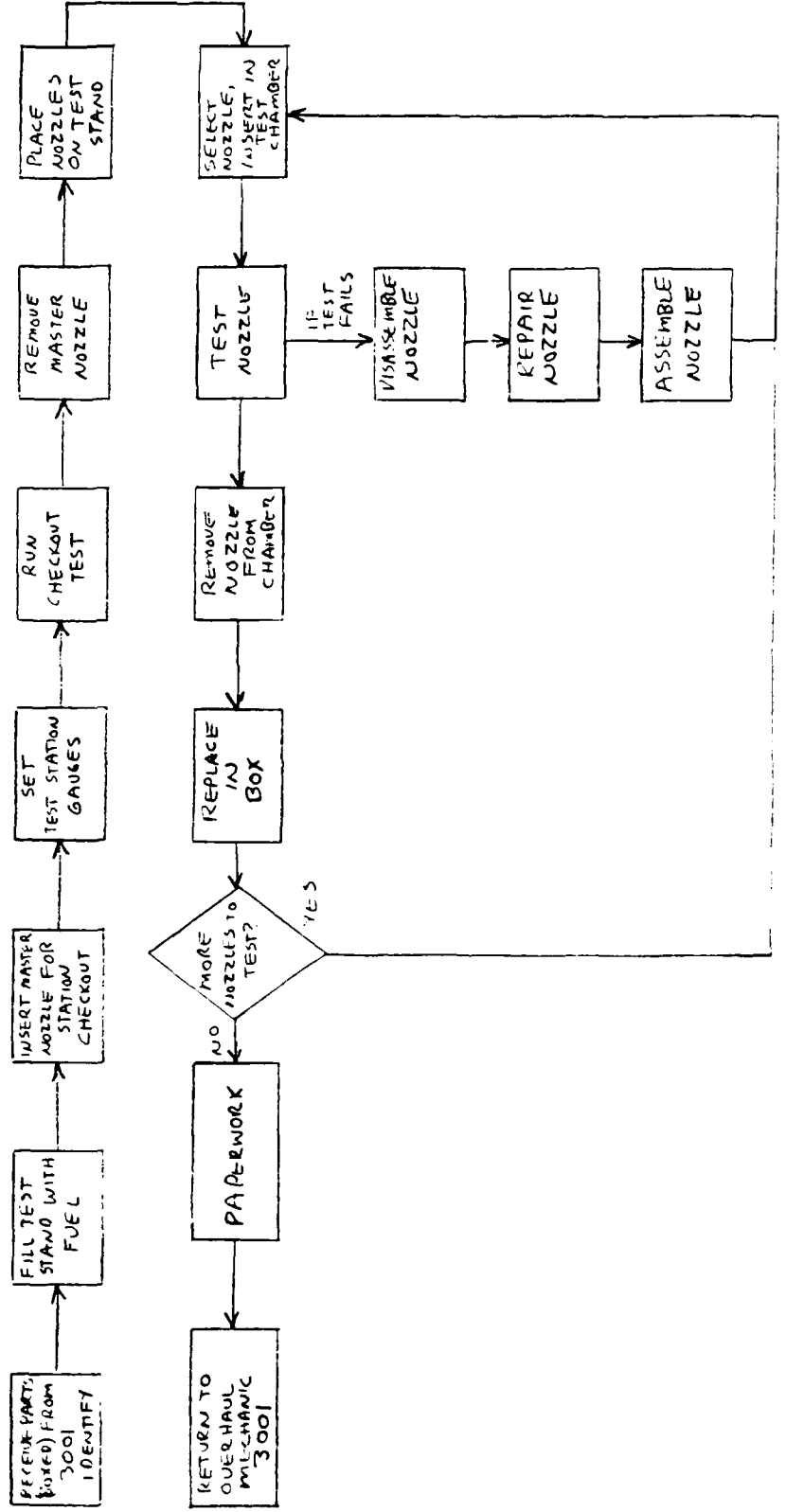
PCN
50134A
96515A
96555A



MATPCB NOZZLES (TEST)

WCD
CBE4T2
CBE4T2
CBE4T3
CTECOG

PCN
50135A
50138A
50136A
98031A



MATPCB NOZZLES (OVERHAUL)

PCN
50136A
50135A
50138A
98031A

WCD
CBE403
CBE402
CBE402
CBE406

RECEIVE
FROM MANIFOLD
DISASSEMBLY
MATPCB

DEHAVAN
NOZZLES
w/NUTS

P7 P2
XCELLO
NOZZLES
w/NUTS

NUTS

TRAY
NOZZLES

TRAY
NOZZLES

TRAY
NUTS

RETURN
TO MANIFOLD
ASSEMBLY
MATPCB

DISASSEMBLE

DISASSEMBLE

CLEAN

BOX
NOZZLES

SELL
EXCESS
TO
SUPPLY

CLEAN

INSPECT

SANDBLAST
CLEAN
INSPECT

FINAL
ASSEMBLY

MEASURE
DUSHINGS

SAND-
BLAST
NUTS

CLEAN

MOVE TO
TEST
E108

LAP

MEASURE
AND
INSPECT
NUTS

ASSEMBLE

PARTIAL
ASSEMBLE

INSPECT

INSTALL
METERING
RING

LAP

DISASSEMBLE

CLEAN

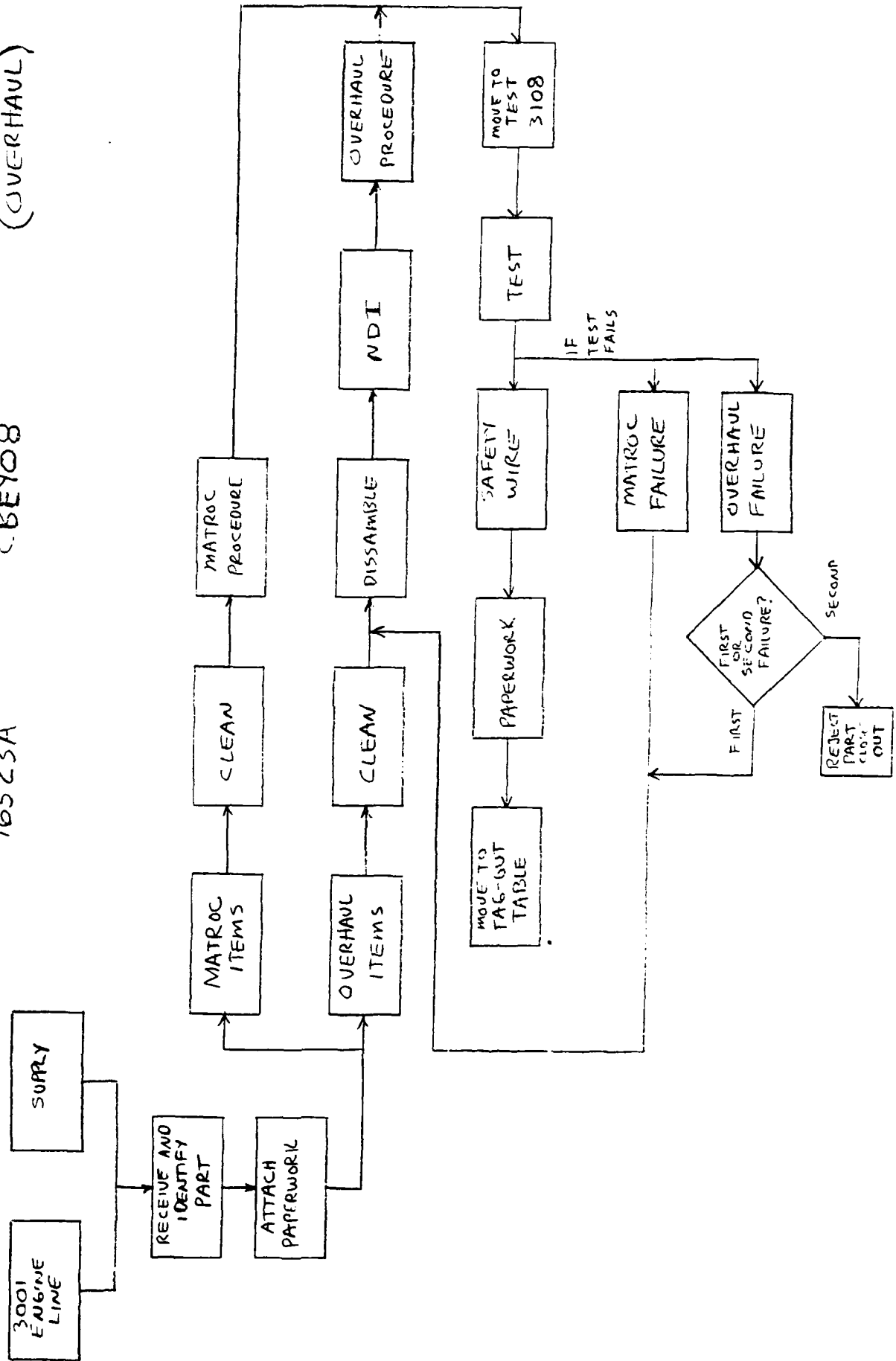
3001
ENGINE
LINE

Supply

PCN
96523A

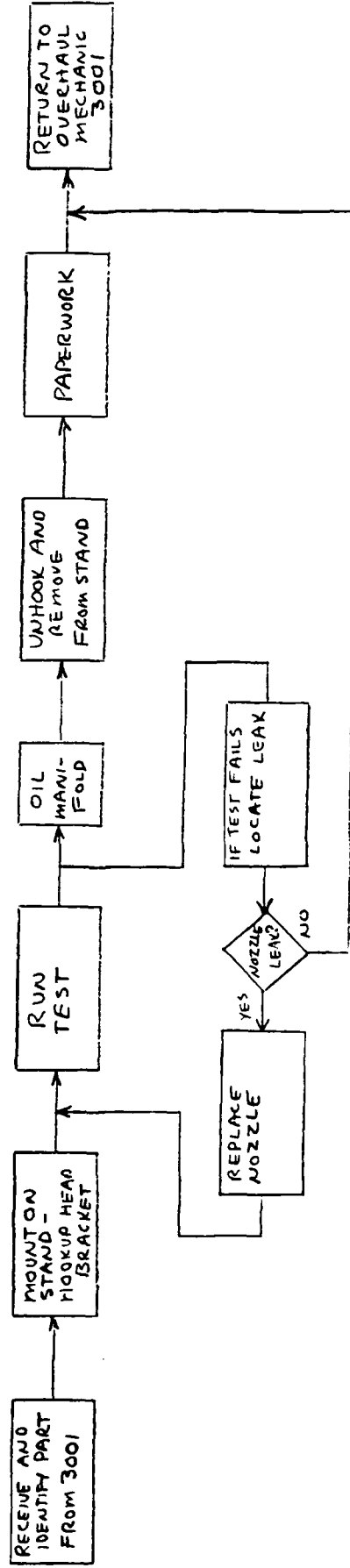
WCD
CBEY08

MATPCB
PUMP
(OVERHAUL)



MATPCB
MANIFOLDS
(TEST)

PCN	WCD
49802A	CBE4T)
49806A	CBE4TI
49808A	CBE4TI
49810A	CBE4TI
98057A	CTEC04
98034A	CTEC04
98042A	CTEC04
98043A	CTEC04



3.0 80/20 WORKLOAD ANALYSIS

An 80/20 Workload Analysis for MATPCB was performed by MDMSC using information obtained from OC-ALC Analysis reports. Using the earned hours reported by control number, a list was generated that represented 80% of the workload. An updated list was formed by reviewing the recent history of items processed and replacing those PCN'S that were no longer relevant with presently processed items of equal or greater earned hours. The following is an updated list of PCN'S and WCD'S representing 80% of MATPCB'S workload:

<u>PNC'S</u>	<u>WCD'S</u>	<u>PCN'S</u>	<u>WCD'S</u>
38644A	CBEM19 CBEM20	38685	CBEM13 CBEM14
38690A	CBEM07 CBEM08	38691A	CBEM10 CBEM11
49802A	CBE401 CBE4T1	49806A	CBE401 CBE4T1
49808A	CBE401 CBE4T1	49810A	CBE401 CBE4T1
50067A	CBEM29 CBEM30 CBEM31	50134A	CBEY10 CBEY11
50135A	CBE402 CBE4T2	50138A	CBE402 CBE4T2
50136A	CBE403 CBE4T3	96515A	CBEY06 CBEY07
96523A	CBEY08 CBEY09	96555A	CBEY16 CBEY17
97150A	CBE404 CBE4T4	97178A	CBE405 CBE4T5
98021A	CBEC05 CTEC05	98031A	CBEC06 CTEC06

3.0

80/20 WORKLOAD ANALYSIS

(CON'T)

<u>PCN'S</u>	<u>WCD'S</u>	<u>PCN'S</u>	<u>WCD'S</u>
98034A	CBEC04 CTEC04	98042A	CBEC04 CTEC04
98043A	CBEC04 CTEC04	98057A	CBEC04 CTEC04
98202A	CREZ01	98206A	CBEZ02 CBEZ94

3.1

VALIDATION

During the assessment the 80/20 control numbers were determined to be fairly representative of the workload. Included is a copy of the 80/20 list.

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~~Article 104 is amended to read:~~
~~Sec. 105 (b) (2) amended to read:~~

3117

UNIT 24 20. 224. 232. 249. 265. 282. 297 (259+532), 308 116H (259+532) WH 5501 LB

МАТРСВ

~~SECRET~~ ~~CONFIDENTIAL~~

Copy on

[illegible]

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SW

[illegible]

25% A

4.0

DATA COLLECTION

The following Data sheets used for th collection of data were found applicable to MATPCB:

- .Operation Profile
- .Manpower Profile
- .Assembly/Disassembly Profile
- .Equipment Profile
- .Envelop Profile

Parallel Process Profiles were found not to be applicable to this RCC. While the Manifolds and Nozzles were seperated and worked on seperately. The same nozzles that were removed from the manifold did not have to be reinstalled into the same manifold. There are enough reworked nozzles available for immediate replacement in the manifolds at the appropriate time. Therefore a Parallel Process Profile was not needed. Operation Profiles were developed primarily from shop interviews. The other profiles were developed by MATPCB supervisors through coordination with the General Foreperson.

4.1

DATA COLLECTION PROCESS

An Operation Profile sheet was developed for each WCD identified from the PCN'S listed on the 80/20 Analysis. Most PCN'S had two or three WCD'S. In most cases one WCD was the repair/overhaul WCD and the second WCD was the test WCD. In all cases the part was not considered complete until the complete repair/overhaul WCD was filled out, stamped and signed. The General Foreperson identified the appropriate MATPCB supervisor who advised which shop personnel were responsible for each WCD. MDMSC personnel then conducted the Operation Profile interview with the appropriate shop personnel. The shop mechanics provided the necessary information and data for the Operation Profiles.

The operators were interview to determine what operations and processes were actually occurring on the work control document (WCD) associated with the PCN. If there was a discrepancy with the WCD and what was actually occurring, it was noted in the source comments column of the Operation Profile and handled appropriately in the data columns. All transit times, flow times, manpower and equipment codes and times, and occurrence factors were determined primarily by operator information.

All profile sheets were reviewed for completeness and correctness and were processed according to instructions and accuracy of information given.

EQUIPMENT PRC LE

NAME		ALC		DATE		RCC		SHEET		OF				
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER RCCs (i.e. TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ	SHIFT	DOWN TIME	MTBF	MTTR					
OC 0945	TEST STAND Pump	2	2	2	30	1	4	15	4	0	1	1	5139	
OC 0975	TEST STAND Pump	2	2	2	30	1	4	25	4	0	1	1	0889	
OC 5139	Test Stand Pump	2	2	2	30	1	4	15	4	0	1	1	0945	
OC 0934	TEST STAND	2	2	2	30	1	4	30	4	0	1	1		

OC 3024	NOZ - CLNR	1	1	1	30	1	4	60	1	0	1	48		
OC 4275	TEST STAND	2	2	2	30	1	4	45	4	0	1	1		

OC 4133	WATER TANK	1	1	1	30	1	1	NA	NA	0	1	20		
OC 4134	WATER TANK	1	1	1	30	1	1	NA	NA	0	1	20		
OC 4136	WATER TOWER	1	1	1	30	1	1	NA	NA	0	1	20		

EQUIPMENT PRO _E

NAME _____		ALC _____		DATE _____		RCC _____		SHEET _____ OF _____			
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME			PERCENT USED FOR OTHER RCCs (i.e. TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME				
BEN 60	WORK BENCH	1	1	1					1		
BEN 12	WORK BENCH	1	1	1					1		
BEN 48	WORK BENCH	1	1	1					1		
BEN 40	WORK BENCH	1	1	1					1		
BEN 410	WORK BENCH	1	1	1					1		
BEN 411	WORK BENCH	1	1	1					1		
BEN 49	WORK BENCH	1	1	1					1		
BEN 50	WORK BENCH	1	1	1					1		
BEN 46	WORK BENCH	1	1	1					1		
BEN 44	WORK BENCH	1	1	1					1		
BEN 43	WORK BENCH	1	1	1					1		
BEN 45	WORK BENCH	1	1	1					1		

EQUIPMENT PRECISE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET _____ OF _____				
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME			PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	PREVENTIVE MAINT.	DOWN TIME	BREAKDOWN REPAIR TIME		MIN	MAX		
					FREQ.	SHIFT	MTBF	MTTH				
BEN 1	WORK BENCH											
BEN 42	WORK BENCH											
BEN 21	WORK BENCH										BEN 22	
BEN 22	WORK BENCH										BEN 21	
BEN 14	WORK BENCH											
BEN 433	WORK BENCH											
BEN 436	WORK BENCH											
BEN 419	WORK BENCH											
BEN 53	WORK BENCH											
BEN 55	WORK BENCH											
BEN 56	WORK BENCH											
BEN 434	WORK BENCH											

EQUIPMENT PROFILE

OC Axx

NAME		ALC		DATE		29 JUN 89		RCC		MATPCB		SHEET		OF	
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR	MIN		MAX			
OC 4278	TEST STAND Noble test stand	2	2	2	30	1	1	180	8	0	1	1	4743	Christiansberry	
OC 4132	WTRTANK Rinse, Cold	1	1	0	1	1,2		365	0.5	0	10	30	4132 4134 4149	Collins	
OC 4947	VDCRSP Vapor Diagram	1	1		1	1,2		90	18	10	1	30		Collins	

OC 4137	US FERTANK Ultrasonic Fertilizer Tank	1	1	0	1	1,2		180	1.5	0	10	20		Collins	
OC 4561	WTRPMP Water Motor Pump														
OC 4602	ALIGN FIXT Aligning Fixture														
OC 4140	CHMTANK Ultrasonic Rinse	1	1	0	1	1,2		180	1.5	10	10	30		Collins	

Y: 0. 13 p.p. 304
 Not orig. equipment
 EQUIPMENT PRC LE

OC
 xxx

=MC

NAME		ALC		DATE		29 JUN 89		RCC		MATPCR		SHEET		OF	
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER RCCs (a.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME		MIN		MAX			
								MTBF	MTTR						
OC 0972	TEST STAND	2	2	2	3	1	1	30	4	0	1	1	0223	M.C.	
OC 0701	TEST STAND Nagle test stand	4	4	4	30	1	4	30	8	0	1	1	0702, 0703, 0705		
OC 0702	TEST STAND Nagle test stand	4	4	4	30	1	4	30	8	0	1	1	0701, 0703, 0705		
OC 0703	TEST STAND Nagle test stand	4	4	4	30	1	4	30	8	0	1	1	0701, 0702, 0705		
OC 0705	TEST STAND Nagle test stand	5	5	5	30	1	1	14	1	0	1	1	0701, 0702, 0703	M.C.	
OC 0952	TEST STAND Nagle test stand	1	1	1	30	1	1	180	1	0	1	1			
OC 0947	TEST STAND	1	1	1	3	1	1	180	1	0	1	1	NONE	NON-CHRISTIAN-BENTLEY	
OC 0229	PRM. TEST FPI Bench?	1	1	1	0	1	0	30	4	0	1	1			
OC 0889	TEST STAND H. pump	2	2	2	30	1	2	30	4	0	1	1	0925		
OC 0973	TEST STAND	1	1	1	3	1	1	45	16	0	1	1	NONE	MONA CHRISTIAN-BENTLEY	
OC 0883	TEST STAND	2	2	2	30	1	1	30	4	0	1	1	0972		
OC 0948	TEST STAND H. stand	1	1	1	3	1	1	180	1	0	1	1	NONE	M.C.	

EQUIPMENT PR FILE

DC S XXX

NAME _____		ALC _____		DATE 29 JUN 89		RCC MATPCLB		SHEET _____ OF _____					
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME				PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF		MTTR	MIN		
OC 3338	CHMTANK Acid bath	1	1	1	90	1	0.1	30	4	0	1	1	JONES? BROWN?
OC 3349	CHMTANK Alkaline	1	1	1	0	0	0	30	4	0	1	1	BROWN
OC 3348	CHMTANK Alkaline Peroxide	1	1	1	90	1	0.1	30	4	0	1	1	JONES? BROWN?
OC 3346	CHMTANK Alkaline Peroxide	1	1	1	90	1	0.1	30	4	0	1	1	JONES
OC 3351	CHMTANK Alkaline Peroxide	1	1	1	90	1	0.1	30	4	0	1	1	JONES
OC 3250	CHMTANK Alkaline	1	1	1	0	0	0	30	4	0	1	1	BROWN
OC 3028	LAPP MACH Lap scale + rinses	1	1	1	1	1	2	8	12	0	1	1	

OC 3020	CHMTANK Peroxide	1	1	1	0	0	0	30	2	10	1	96	BROWN
OC 3022	CHMTANK Cleaning tank	1	1	0	1	1,2		90	24	10	1	96	Collins
OC 3023	CHMTANK Cleaning tank	1	1	1				30	2	10	1	96	BROWN
OC 3391	LAPP MACH Lap scale + rinses	1	1	1	1	1	2	8	12	0	1	1	

xxx

EQUIPMENT PROFILE

[illegible]

0 xxx

SHEET ____ OF ____

[illegible]

xx
10

[illegible]

EQUIPMENT FILE

REVISOR EQUIPMENT HISTORY
ONLY REFERS TO OPERATION PRACTICES.

STOP

NAME Christenberry ALC DC

DATE 5-15-77

NCC MATPLB

SHEET 1 OF 1

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME		PERCENT USED FOR OTHER NCCS (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		SHIFT			FREQ.	SHIFT	DOWN TIME	UNPLANNED BREAKDOWN REPAIR TIME						
		1st	2nd	3rd				MIN	MAX					
UC	J79 Nozzle (L/S)													Christenberry
4777	Test Stand	002	002	002	030	1	001.0	18.0	0002.0	X	0001	0001	4743	UC
UC	J79 Nozzle (R/S)													Christenberry
4777	Test Stand	002	002	002	030	1	001.0	18.0	0002.0	X	0001	0001	4743	UC
UC	J57/IF33 Nozzle													Christenberry
4775	Test Stand	005	005	005	030	1	001.0	014	0001.0	X	0001	0001	4771	UC
UC	Manifest Test Stand													Christenberry
1132	Stand	002	002	002	030	1	001.0	18.0	0002.0	X	0001	0001	1133	UC
UC	IF41 HP Pump													Christenberry
1141	Test Stand	002	002	002	030	1	001.0	015	0001.0	X	0001	0001	1145	UC
UC	IF41 LP Pump													Christenberry
1178	Test Stand	001	001	001	030	1	001.0	18.0	0002.0	X	0001	0001	None	UC
UC	IF32 HP Pump													Christenberry
5139	Test Stand	002	002	002	030	1	001.0	18.0	0002.0	X	0001	0001	5145	UC
UC	J57/IF33 ME Pump													Christenberry
1175	Test Stand	002	002	002	030	1	001.0	030	0004.0	X	0001	0001	1117	UC
UC	J71 HP Pump													Christenberry
4775	Test Stand	002	002	002	030	1	001.0	030	0004.0	X	0001	0001	4734	UC
UC	J79 ME Pump													Christenberry
4772	Test Stand	002	002	002	030	1	001.0	030	0004.0	X	0001	0001	4773	UC
UC	IF30 Hydraulic Pump													Christenberry
1948	Test Stand	001	001	001	030	1	001.0	17.0	0002.0	X	0001	0001	1949	UC
UC	J79 Nozzle Oil													Christenberry
1947	Flush Stand	001	001	001	030	1	001.0	18.0	0002.0	X	0001	0001	1948	UC
UC	IF30 Wash Fluid	001	001	001	030	1	001.0	045	0016.0	X	0001	0001	1949	UC
1973	Flush Stand													Christenberry

ORIGINS
INSTRUMENT
CRASH IT
SHOWS MANY
MAY BE
OF EQUIPMENT
WHICH IS NOT
SHOWN ON
AND OPERATOR
PRACTICES.

15C-2000111

11100

EQUIPMENT PROFILE

NAME	ALC	DATE	ICC	SHEET		SOURCE				
				OF	OF					
EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME			PERCENT USED FOR OTHER INCC (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	
	1st	2nd	3rd	PREVENTIVE MAINT.	DOVTH TIME	UNPLANNED DOWNTIME				
				FREQ.	SHIFT	TIME	UNPLANNED DOWNTIME	TIME	TIME	
I-14756	1	1	1	0	0	0	18.25	Repair	1	Collins
Dowling Fixture	1	1	1	0	0	0	18.25	Repair	1	Collins
I-14758	1	1	1	0	0	0	18.25	Repair	1	Collins
Drill Jig	1	1	1	0	0	0	18.25	Repair	1	Collins
I-14759	1	1	1	0	0	0	18.25	Repair	1	Collins
Drill Jig	1	1	1	0	0	0	18.25	Repair	1	Collins
I-690-E										
Adapter										
I-1817-E										
Plug - Ref. valve										
I-13835										
Timing - First										
I-1178	1	1	1	1	1.2	90	24.0		2	Collins
Cleaning tank	1	1	1	1	1.2	30	18.0		3	Collins
Vapor Degreaser										
I-1177	1	1	1	1	1.2	30	18.0		3	Collins
Cleaning tank										

2

EQUIPMENT PROFILE

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PRECEDENCE RANK	DOWNTIME		PERCENT USED FOR OTHER JOBS (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd		PRECEDENCE RANK	DOWN TIME				
OC 4137	Degreaser	1	1	0	1	1-2	30	48.0	10 / 30	0	Collins
OC 2848	P-D-680	1	1	0	1	1-2	90	21.0	10 / 30	0	Collins
OC 3022	Perningrate	1	1	0	1	1-2	90	21.0	10 / 30	OC 3024	Collins
OC 4139	Alkaline	1	1	0	1	1-2	180	21.0	10 / 30	0	Collins
OC 4132	Ultra sonic cleaner	1	1	0	1	1-2	365	1.1	10 / 30	OC 4133 OC 4134	Collins
OC 4137	Trichlorate Fluorocarbon	1	1	0	1	1-2	180	1.1	10 / 20	0	Collins
OC 4140	Ultra sonic cleaner	1	1	0	1	1-2	180	1.1	10 / 30	0	Collins
OC 4131	Hot Air Dryer	1	1	0	1	1-2	365	1.1	10 / 30	OC 4135 OC 4136	Collins
OC 4132	Sandblaster	1	1	0	1	1-2	90	1.1	1 / 1	0	Collins

NAME _____ ALC _____ DATE _____ HCC _____ SHEET _____ OF _____

50067A - 1st

50067A - 1st

EQUIPMENT PROFILE

[illegible]

EQUIPMENT PROFILE

NAME <u>Delaware</u>		ALC <u>OC-ALC</u>		DATE		ICC <u>MATPCS</u>		SHEET <u>4</u> OF <u>4</u>						
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER ICCs (i.e. TIME NOT AVAILABLE)	ENVIRONMENTAL UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	THRO.	SHIFT	DOWN TIME	UNPLANNED REPAIR TIME	THRO.	SHIFT				
OC	Tanks # 5	1	1	1	0	0	0	0	0	0	0	1/96	0	
3032	Hydrazine Potassium Permanganate	1	1	1	0	0	0	0	0	0	0	1/96	0	
OC	Tanks # 7	1	1	1	0	0	0	0	0	0	0	1/96	0	
3034	Hydrazine Potassium Permanganate	1	1	1	0	0	0	0	0	0	0	1/96	0	
OC	Tanks # 4	1	1	1	0	0	0	0	0	0	0	1/96	0	
3031	Acetylene	1	1	1	0	0	0	0	0	0	0	1/96	0	
OC	Hydrazine	1	1	1	0	0	0	0	0	0	0	1/96	0	
3030	Hydrazine	1	1	1	0	0	0	0	0	0	0	1/96	0	
OC	Tanks # 3	1	1	1	0	0	0	0	0	0	0	1/96	0	
3019	Hydrazine	1	1	1	0	0	0	0	0	0	0	1/96	0	
OC	Tanks # 2	1	1	1	0	0	0	0	0	0	0	1/96	0	
3023	Hydrazine	1	1	1	0	0	0	0	0	0	0	1/96	0	
OC	Tanks # 1	1	1	1	0	0	0	0	0	0	0	1/96	0	
4947	Di-glycine	1	1	1	0	0	0	0	0	0	0	1/96	0	
OC	Acetylene	1	1	1	0	0	0	0	0	0	0	1/96	0	
1178	Chemical	1	1	1	0	0	0	0	0	0	0	1/96	0	
	Tanks	1	1	1	0	0	0	0	0	0	0	1/96	0	
	Tanks # 14-15-16	1	1	1	0	0	0	0	0	0	0	1/96	0	
OC	Hydrazine	1	1	1	0	0	0	0	0	0	0	1/96	0	
4135	Hydrazine	1	1	1	0	0	0	0	0	0	0	1/96	0	
OC	Tanks # 13	1	1	1	0	0	0	0	0	0	0	1/96	0	
4132	Hydrazine	1	1	1	0	0	0	0	0	0	0	1/96	0	
OC	Tanks # 11 & 9	1	1	1	0	0	0	0	0	0	0	1/96	0	
4134	Hydrazine	1	1	1	0	0	0	0	0	0	0	1/96	0	

3030

EQUIPMENT PROFILE

NAME Quercus ALC OC-ALC DATE _____ SHEET 3 OF 3

ICC MATPCS

COMBINATION CODE	COMBINATION TYPE/DESCRIPTION	QUANTITY PER SMT			PREVENTIVE MAINT.			DOWN TIME		UNREPAIRABLE REPAIR TIME (HRS)	PERCENT USED FOR OTHER ICC (1-9 TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	THRO.	SHFT	DOWN TIME	UNREPAIRABLE						
OC	Tank #5	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
3032	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
3034	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
3031	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
3030	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
3019	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
3033	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	30	8.0	10%	1	96		Collins
4147	Hydromin Pressure	1	1	0	0	0	0	90	44.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	90	44.0	10%	1	96		Collins
1178	Hydromin Pressure	1	1	0	0	0	0	90	44.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	90	44.0	10%	1	96		Collins
4135	Hydromin Pressure	1	1	0	0	0	0	90	44.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	90	44.0	10%	1	96		Collins
4132	Hydromin Pressure	1	1	0	0	0	0	90	44.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	90	44.0	10%	1	96		Collins
4140	Hydromin Pressure	1	1	0	0	0	0	90	44.0	10%	1	96		Collins
OC	Hydromin Pressure	1	1	0	0	0	0	90	44.0	10%	1	96		Collins

EQUIPMENT PROFILE

NAME <u>TF 33-19</u>		ALC <u>OC-ALC</u>		DATE		NO: <u>DATA</u>		SHEET <u>3</u> OF <u>3</u>							
COMPONENT CODE	COMPONENT TYPE/DESCRIPTION	QUANTITY PER SHIRT			PNEUMATIC HANT			DOWN TIME			UNREPAIRABLE TIME	PERCENT USED FOR OTHER THGS (i.e. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FILED	SHIFT	DOWN TIME	UNREPAIRABLE TIME	UNREPAIRABLE TIME						
OC	Tanks #5	1	1	0	0	0	0	0	0	0	0	10%	1		
3033	Hydrochloric Perchloric														
OC	Tanks #7	1	1	0	0	0	0	0	0	0	0	10%	1		
3034	Hydrochloric Perchloric														
OC	Hydrochloric Perchloric	1	1	0	0	0	0	0	0	0	0	10%	1		
3037	Tanks #4														
OC	Hydrochloric Perchloric	1	1	0	0	0	0	0	0	0	0	10%	1		
3038	Tanks #3														
OC	Hydrochloric Perchloric	1	1	0	0	0	0	0	0	0	0	10%	1		
3039	Tanks #2														
OC	Hot water	1	1	0	0	0	0	0	0	0	0	10%	1		
3040	Tanks #6														
OC	Hot water	1	1	0	0	0	0	0	0	0	0	10%	1		
4947	De-greaser														
OC	Perchloric Perchloric	1	1	0	0	0	0	0	0	0	0	10%	1		
1178	PDG 80														
OC	Chemical Tanks	1	1	0	0	0	0	0	0	0	0	10%	1		
4135	Tanks #14-15-16														
4136	Hot air														
4137	Tanks														
OC	Tanks #13														
4138	Hot water	1	1	0	0	0	0	0	0	0	0	10%	1		

8015
4138

COLLINS

EQUIPMENT PROFILE

NAME TF33-P1 ALC CC-ALC DATE _____ IICC MAEPES SHEET 2 of 2

CONTAINER CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SIFT			PRECEDENCE RANKING			DOWN TIME		PERCENT USED FOR OTHER IICCS (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	PREC.	SIFT	DOWN TIME	DISCONTINUED BREAKDOWN REPAIR TIME MIN MAX					
OC	Tanks #5	1	1	1	0	0	0	0	0	0	196		Collins
3023	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196		Collins
OC	Permanganate	1	1	1	0	0	0	0	0	0	196		Collins
3024	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196		Collins
OC	Permanganate	1	1	1	0	0	0	0	0	0	196		Collins
3021	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196		Collins
OC	Permanganate	1	1	1	0	0	0	0	0	0	196		Collins
3020	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196		Collins
OC	Permanganate	1	1	1	0	0	0	0	0	0	196		Collins
3019	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196		Collins
OC	Permanganate	1	1	1	0	0	0	0	0	0	196		Collins
3023	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196		Collins
OC	Permanganate	1	1	1	0	0	0	0	0	0	196		Collins
4947	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196		Collins
OC	Permanganate	1	1	1	0	0	0	0	0	0	196		Collins
1178	Chemical Tanks	1	1	1	0	0	0	0	0	0	196		Collins
OC	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196		Collins
4135	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196	OC-4131	Collins
4136	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196	OC-4136	Collins
4137	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196	OC-4133	Collins
4138	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196	OC-4144	Collins
OC	Test Fluid	1	1	1	0	0	0	0	0	0	196		Collins
11146	Hydrochloric Acid	1	1	1	0	0	0	0	0	0	196		Collins

EQUIPMENT PROFILE

NAME <u>RAY Jones</u>		ALC <u>OC</u>		DATE <u>1228X89</u>		RCC <u>MAT-P-B</u>		SHEET <u>5</u> OF <u>6</u>							
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME		PERCENT USED FOR OTHER RCC'S (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE	
		1st	2nd	3rd	FREQ.	SHIFT	DOWNTIME	UNLEAKDOWN/REPAIR TIME	MIN		MAX				
Do NOT USE	PWA 35529 Block														
	PWA 35530 Gasket														
	PWA 35531 Fixture														
Do NOT USE	PWA 35809 Block														
Do NOT USE	PWA 4984 Stand														
Do NOT USE	PWA 1580 Sking														
OC 6560	ALKALINE Permanganate VAT, Reservoir	1	1		090	00/00/00	30	4		0	1			JONES	
OC 3338	ALKALINE Permanganate VAT, Cleaning	1	1		090	00/00/00	30	4		0	1			JONES	
OC 3348	ALKALINE Permanganate VAT, Cleaning	1	1		090	00/00/00	30	4		0	1			JONES	
OC 3346	ALKALINE Permanganate VAT, Cleaning	1	1		090	00/00/00	30	4		0	1			JONES	
OC 6561	ALKALINE Permanganate VAT, Reservoir	1	1		090	00/00/00	30	4		0	1			JONES	
OC 3351	ALKALINE Permanganate VAT, Cleaning	1	1		090	00/00/00	30	4		0	1			JONES	

CLEANING Procedure

NO. 1

EQUIPMENT FILE

[illegible]

EQUIPMENT PROFILE

AA 12

NAME <u>RAY JONES</u> ALC <u>OC</u> DATE <u>8 MAR 88</u> NCC <u>WAT PC B</u> SHEET <u>7</u> OF <u>4</u>		EQUIPMENT TYPE/DESCRIPTION		QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER NCCs (e.g. TIME NOT AVAILABLE)		ENVELOP UNITS		ALTERNATE EQUIPMENT CODE		SOURCE	
EQUIP/INT CODE		1st	2nd	3rd	FREQ.	SHIFT	DOWNTIME	MTBF	MTTR	MTTR	MTTR	MIN	MAX							
OC	HD 752	4	4	4	0	0	0	1823	36			1	1	0		3			Bussan	
4608	Vise, Bench	1	1	1	1	1	180	30	4			1	1	0		0				
OC	MST-250	3	3	3	1	1	30	30	4			1	1	0		2				
4608	Spring Tester	1	1	1	1	1	30	30	4			1	1	0		0				
OC	PD 680	1	1	1	1	1	30	30	4			1	1	0		0				
1178	VAT, cleaning	1	1	1	1	1	30	30	4			1	1	0		0				
OC	Model CT-60-S	1	1	1	1	1	30	30	4			1	1	0		0				
OC	Degreaser	1	1	1	1	1	30	30	4			1	1	0		0				
OC	128	1	1	1	1	1	30	30	4			1	1	0		0				
0229	Line, Fluorescent Penetrant	1	1	1	1	1	30	30	4			1	1	0		0				
OC	Model 3700	1	1	1	1	1	30	30	4			1	1	0		0				
0229	Booth, Fluorescent Penetrant	1	1	1	1	1	30	30	4			1	1	0		0				
OC	Model G610M	1	1	1	1	1	30	30	4			1	1	0		0				
6025	Magnetic Particle	1	1	1	1	1	30	30	4			1	1	0		0				
OC	PWA 15505-100	1	1	1	1	1	30	30	4			1	1	0		0				
3319	Test Stand	1	1	1	1	1	30	30	4			1	1	0		0				
OC	PWA 15505	1	1	1	1	1	30	30	4			1	1	0		0				
OC	Test Stand	1	1	1	1	1	30	30	4			1	1	0		0				
OC	8-115	1	1	1	1	1	30	30	4			1	1	0		0				
4608	ARBOR Press	3	3	3	1	1	1823	36				1	1	0		2				
OC	Model IP-121	2	2	2	1	1	1823	36				1	1	0		1				
4608	HYD Press	1	1	1	1	1	30	30	4			1	1	0		0				
OC	7/015/0907	1	1	1	1	1	30	30	4			1	1	0		0				
5035	Balance Mach.	1	1	1	1	1	30	30	4			1	1	0		0			Bussan	

EQUIPMENT PROFILE

NAME <u>RAY JONES</u>		ALC <u>OC</u>		DATE <u>9 MAY '89</u>		RCC <u>MATP B</u>		SHEET <u>3</u> OF <u>3</u>						
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME		PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE	
		1st	2nd	3rd	FREQ.	SHIFT	DOWNTIME	DOWN TIME	UNPLANNED/REPAIR TIME HIDE MIN					
OC 4608	SF-102-1156-04-F1 Piston Ring Assembly	1	1	1	0	0	0	0	1825	Repair	0	1/1	φ	Jones BURROWS
OC 4608	SF-102-1162-06-F1 Fixture	1	1	1	0	0	0	0			0	1/1	φ	Jones BURROWS
OC 4608	SF-102-1190-01-M1 Holding Block and Arbor	1	1	1	0	0	0	0			0	1/1	φ	Jones BURROWS
OC 4608	SF-102-1192-01-F1 Fixture and Arbor	1	1	1	0	0	0	0			0	1/1	φ	Jones BURROWS
OC 4608	8-115 Arbor Press	3	3	3	0	0	0	0	1825		0	1/1	φ	Jones BURROWS
OC 2846	D-325465 Drill Press	1	1	1	0	0	0	0	365		0	1/1	φ	Jones BURROWS
OC 4608	2054 Grage Block	1	1	1	0	0	0	0	1825	Work	0	1/1	φ	Jones BURROWS
OC 1178	PD680 VAT, Cleaning	3	3	3	0	0	0	0	30		0	1/1	φ	Jones BURROWS
OC 4512	MODEL CT-60-S Degreaser	1	1	1	0	0	0	0	30		0	1/1	φ	Jones BURROWS
OC 6025	MODEL G610M Magnetic Particle	1	1	1	0	0	0	0	30		0	1/1	φ	Jones BURROWS
OC 0229	128 Line, Fluorescent Penetrant	1	1	1	0	0	0	0	30		0	1/1	φ	Jones BURROWS
OC 0229	MODEL 37000 Booth, Fluorescent Penetrant	1	1	1	0	0	0	0	30		0	1/1	φ	Jones BURROWS

98202

EQUIPMENT PROFILE

NAME RAY JONES ALC OC DATE 5 MAY '89 RCC WAT P. B SHEET 1 OF 2

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME			PERCENT USED FOR OTHER RCCs (i.e. TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		SHIFT			FREQ.	DOWN TIME		BREAKDOWN REPAIR TIME	UNPLANNED					
		1st	2nd	3rd										
OC 4608	558-2-01352 SPANNER	2	2	0	0	0	0	0	1825	1825	NONE	1	1	BUSSERS
OC 4608	558-2-01355 SPANNER	2	2	1	1	1	1	1			NONE	1	1	
OC 4608	558-2-01358 SLEEVE	2	2	1	1	1	1	1			NONE	1	1	
OC 4608	558-1-01351 Tool, Insertion	1	1	1	1	1	1	1			NONE	1	0	
OC 4608	558-1-01353 Tool, Crimping	2	2	1	1	1	1	1			NONE	1	1	
OC 4608	558-1-01354 Serrated Key	2	2	1	1	1	1	1			NONE	1	1	
OC 4608	558-1-01356 Tool, Crimping	2	2	1	1	1	1	1			NONE	1	1	
OC 4608	558-1-01357 Serrated Key	2	2	1	1	1	1	1			NONE	1	1	
OC 4608	6873047 GAGE	1	1	1	1	1	1	1	1825	1825	NONE	1	0	
OC 1178	CMH8 PD680, VAT	3	3	1	1	1	1	1	30	4	TIME NOT AVAILABLE	1	2	
OC 4612	COMACOTYPE 1 Spring Tester	1	1	0	0	0	0	0	180	36	NONE	1	0	BUSSERS
OC 1188	558-1-01318 Fixture, Test	1	1	1	1	1	1	1			NONE			

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760223

EQUIPMENT PROFILE

NAME RAY Jones ALC OC DATE 4 MAY 89 NCC MATLAB SHEET 1 OF 4

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME		PERCENT USED FOR OTHER NCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWNTIME	UNPLANNED REPAIR TIME MTBF	MTTR				
OC 4608	STD 67017 Fixture	2	2	2	0	0	0	0	1825	Replac	1	1	Excessions
OC 0973	PWA 15501 TEST STAND	1	1	1	1	1	1	1			1	0	
OC 0897	TEST STAND	1	1	1	1	1	1	1	1	1	1	1	Excessions
OC 0947	PWA 15512 Flush STAND	1	1	1	1	1	1	1			1	0	
OC 4788	STD 62542 TEST Cover	1	1	1	1	1	1	1			1	0	
OC 4788	STD 62543 Adapter	1	1	1	1	1	1	1			1	0	
OC 4788	STD 65385 Adapter	1	1	1	1	1	1	1			1	0	
OC 4788	STD 65386 Adapter	1	1	1	1	1	1	1			1	0	
OC 4788	STD 62496 Adapter, Inlet	1	1	1	1	1	1	1			1	0	
OC 4788	STD 61431 Filter	1	1	1	1	1	1	1			1	0	
OC 4788	STD 67003 Fixture	1	1	1	1	1	1	1			1	0	
OC 4788	STD 62531 Adapter	1	1	1	1	1	1	1	182	Replac	1	0	Excessions

EQUIPMENT PROFILE

NAME RAY JONES ALC OC DATE 4 MAY 89 RCC MMTR-8 SHEET 3 OF 4

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME		PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UTILS		ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWNTIME	DREAR/DOWN REPAIR TIME	MIN		MAX			
OC 4788	STD 65263 Adapter	1	1	1	0	0	0	1825	4	0	1	1	0	1
OC 1178	PD680	1	1	1	1	1	1	30	4	0	1	1	0	1
OC 4947	MODEL CT-60-S DEGREASER	1	1	1	1	1	1	30	4	0	1	1	0	1
OC 0229	MODEL 37000 Penetrant Booth	1	1	1	1	1	1	30	4	0	1	1	0	1
OC 0229	128 Penetrant Line	1	1	1	1	1	1	30	4	0	1	1	0	1
OC 6025	MODEL G610M Magnetic Particle Booth	1	1	1	1	1	1	30	4	0	1	1	0	1
OC 5171	OVEN	1	1	1	0	0	0	60	4	0	1	1	0	1
OC 4512	DEGREASER	1	1	1	1	1	1	30	4	0	1	1	0	1
OC 0267	MODEL 454-2 Ultrasonic Center	1	1	1	1	1	1	30	4	0	1	1	0	1
OC 0306	Rinse, Spray Rinse	1	1	1	1	1	1	30	4	0	1	1	0	1
OC 0306	Oven	1	1	1	1	1	1	30	4	0	1	1	0	1
OC 0306	ALKALINE TANK	1	1	1	1	1	1	30	4	0	1	1	0	1

EQUIPMENT PROFILE

[illegible]

EQUIPMENT PROFILE

NAME <u>RAY Jones</u>		ALC <u>OC</u>		DATE <u>1 MAY 89</u>		NCC <u>MATER</u>		SHEET <u>3</u> OF <u>6</u>					
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME		PERCENT USED FOR OTHER NCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS	ALTERIATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWNTIME	UNPLANNED DREKDOWN REPAIR TIME	MTTR				
OC 4600	PWA 8575 LAP	1	1	0	0	0				1825 Repairs	1/1	φ	Excess
OC 1038	PWA 15708A Test Stand	1	1								1/1	φ	
OC 4780	PWA 16666 Plug	1	1								1/1	φ	
OC 4705	PWA 16667 Fixture	1	1								1/1	φ	
OC 4705	PWA 16669 Locator	1	1								1/1	φ	
OC 4705	PWA 16670	1	1								1/1	φ	
OC 4705	PWA 16671 Cutter	1	1								1/1	φ	
OC 4705	PWA 16673 Jig	1	1								1/1	φ	
OC 4705	PWA 16675 Drift	1	1								1/1	φ	
OC 4705	PWA 16677 Squeezer	1	1								1/1	φ	
OC 4705	PWA 16672 Cutter	1	1								1/1	φ	
OC 4705	700D76 Fixture	1	1	0	0	0			1825 Repairs		1/1	φ	Excess

EQUIPMENT PROFILE

NAME <u>Ray Jones</u>		ALC <u>OC</u>		DATE <u>1 May 89</u>		RCC <u>MATP-8</u>		SHEET <u>6</u> OF <u>6</u>					
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME		PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWNTIME	UNPLANNED REPAIR TIME	MTTR				
OC	SLING												
OC 6560	ALKALINE Permanganate VAT, Reservoir	1	1	1	0	0	0	30	4	0	1	0	Bussan
OC 3338	ALKALINE Permanganate VAT, Cleaning	1	1	1	1	1	1	30	4	0	1	0	Bussan
OC 3348	ALKALINE Permanganate VAT, Cleaning	1	1	1	1	1	1	30	4	0	1	0	Bussan
OC 3346	ALKALINE Permanganate VAT, Cleaning	1	1	1	1	1	1	30	4	0	1	0	Bussan
OC 6561	ALKALINE Permanganate VAT, Reservoir	1	1	1	1	1	1	30	4	0	1	0	Bussan
OC 3351	ALKALINE Permanganate VAT, Cleaning	1	1	1	1	1	1	30	4	0	1	0	Bussan
OC 3350	ALKALINE Permanganate VAT, Cleaning	1	1	1	1	1	1	30	4	0	1	0	Bussan
OC 3349	ALKALINE Permanganate VAT, Cleaning	1	1	1	1	1	1	30	4	0	1	0	Bussan
OC 2848	PD 680 Flush Tank	1	1	1	1	1	1	30	4	0	1	0	Bussan
OC 3125	Oven	1	1	1	1	1	1	36.5	36	0	1	0	Bussan
OC 4600	Drill Machine	1	1	1	0	0	0	36.5	36.5	0	1	0	Bussan

EQUIPMENT PROFILE

[illegible]

EQUIPMENT PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET _____ OF _____					
EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			PREVENTIVE MAINT.			DOWNTIME		PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN MAX	ALTERNATE EQUIPMENT CODE	SOURCE
		1st	2nd	3rd	FREQ.	SHIFT	DOWN TIME	MTBF	MTTR				
OC1078	PD 680 CLEANING TANK	1	1		1	1/2	4	90	24.0	0	1/2	0	COLLINS
OC4947	VAPOR DEG CLEANING TANK	1	1		1	1/2	4	30	48.0	0	1/3	0	COLLINS
OC4602	DEGRASSER	1	1		1	1	4	30	48.0	0	1/3	0	COLLINS
OC4228	TEST STAND	2	2	2	1	3	6	30	41	0	1/1	0	CHARPENTIER
OC4968	TEST STAND	2	2	2	1	3	6	30	40	0	1/1	0	CHARPENTIER
OC3391	LAPPING MACHINE	1	1	1	1	1	2	8	12	0	1/1	0	—
OC3028	LAPPING MACHINE	1	1	1	1	1	2	8	12	0	1/1	0	—
OC5121	FILTER TESTER	1	1	1	1	1	2	8	12	0	1/1	0	—
OC4132	COLD WATER TANK	1	1	1	1	1	1	2	2	0	1/1	0	—
OC4133	COLD WATER TANK	1	1	1	1	1	1	2	2	0	1/1	0	—

EQUIPMENT PROFILE

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT			DOWNTIME				PERCENT USED FOR OTHER RCCs (+9. TIME NOT AVAILABLE)	ENVELOP UNITS		ALTERNATE EQUIPMENT CODE	SOURCE
		PREVENTIVE MAINT.			UNPLANNED REPAIR TIME		MTTR	MIN		MAX			
		FREQ.	SHIFT	DOWN TIME	MTBF								
BEN40	WEEK-BNCH	1	1	1	NA				→	1	1	NA	op. profiles
BEN41		1	1	1						1	1		
BEN42		1	1	1						1	1		
BEN43		1	1	1						1	1		
BEN44		1	1	1						1	1		
BEN45		1	1	1						1	1		
BEN47		1	1	1						1	1		
BEN49		1	1	1						1	1		
BEN50		1	1	1						1	1		
BEN51		1	1	1						1	1		
BEN53		1	1	1						1	1		
BEN55		1	1	1						1	1		

EQUIPMENT PROFILE

23

[illegible]

MANPOWER PROGRAM

NAME <u>Linda Dandy</u> ALC <u>Diller</u> DATE <u>June 85</u> RCC <u>MINI PC</u> SHEET <u>1</u> OF <u>2</u>																							
SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE						MANPOWER AVAILABLE (HOURS)						ALTERNATE SKILL CODE/LEVEL								
			WORK WEEK			WEEKEND			HOLIDAYS			WORK WEEK				WEEKEND			HOLIDAYS				
			1	2	3	1	2	3	1	2	3	1	2	3		1	2	3	1	2	3		
BP 8255-10	<u>Hydraulic Work</u> <u>Inspector</u> <u>Inspects TOR's, Reports</u> <u>Findings, Overhauls</u> <u>TF41 H.P. Pumps</u>	18	1	0	0	0	0	0	0	0	0	428											NONE
		2	1	0	0	0	0	0	0	0	0	434											
		3	1	0	0	0	0	0	0	0	0	428											
		4	1	0	0	0	0	0	0	0	0	414											
BP 8255-10	<u>Hydraulic Work</u> <u>Overhaul & Test</u> <u>TF41 H.P. Pumps</u>	18	4									1212			107			0					NONE
		2	4									1239			107			0					
		3	6									2569			107			0					
		4	4									1685			107			0					
BP 6905-5	<u>Test Parts Attendant</u> <u>Maintains PM & Equip.</u> <u>Assembles ASSETS</u>	18	1									428			0			0					NONE
		2	1									434			0			0					
		3	1									428			0			0					
		4	1									414			0			0					
BI 5439-9	<u>NDE</u> <u>F.P. Inspection</u> <u>Mag Inspection</u> <u>of parts</u>	18	2									856			0			0					NONE
		2	2									864			0			0					
		3	2									856			0			0					
		4	2									843			0			0					
BP 8255-9	<u>Hydraulic Work</u> <u>Overhauls pumps &</u> <u>manifolds</u>	18	11									4709			107								NONE
		2	11									4783			107								
		3	11									4709			107								
		4	17									7116			107								

MANPOWER PROGRAM

NAME <u>Linda Dandy</u>		ALC <u>Inker</u>		DATE <u>June 85</u>		RCC <u>DATE</u>		SHEET <u>2</u> OF <u>2</u>																			
SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE												MANPOWER AVAILABLE (HOURS)												ALTERNATE SKILL CODE/LEVEL
			WORK WEEK				WEEKEND				HOLIDAYS				WORK WEEK				WEEKEND				HOLIDAYS				
			1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4	
HP 8255-9	Pneumatic Drilling Overhaul nozzles & fuel pumps	1	11	4																							111115
		2	11	4																							
		3	12	3																							
		4	12	3																							
HP 5427-7	Sand blaster Operates sand blasting machine, vapor none vacuum blast.	1	0	1																							111115
		2	0	1																							
		3	1	0																							
		4	1	0																							
HP 5704-5	Forklift Operator maintain & delivers chemicals. Operates forklift for transport of material	1	2																								111115
		2	2																								
		3	2																								
		4	2																								
DP 8255-9	Bench Mch test various end items	1	10	10																							311018
		2	10	10																							
		3	10	10																							
		4	10	10																							
		1																									
		2																									
		3																									
		4																									

WORKLOAD PROFILE

Gebreyehu

NAME TO TEN		ALC		DATE		RCC MTPCB		SHEET 1 OF 1					
ITEM NUMBER		AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER				NO. OF ENVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS	
PCII	(MTPCQT)	J79	CBE M19	4	Ø	1	2	3	4				
NSH	38644A	15-17	CBE M20				59	261	151		44	1.4	
PII													
PCII	(MTPCQE)	TF30	CBE Y06	"		21	17	17	10		5	16.5	
NSH	96515A	P100	CBE Y07										
PII													
PCII	(MTPCQE)	TF30	CBE Y08	"			10	14	15	5		5	15.7
NSH	96523A	P100	CBE Y09										
PII													
PCII	(MTPCQE)	TF30	CBE Y16	"			11	6	6	14		5	16.5
NSH	96555A	7-9	CBE Y17										
PII													
PCII	(MTPCQT)	TF30	CBE Y04	"			26	34	43	60		10	23.6
NSH	97150A	ALL	CBE Y14										
PII													
PCII	(MTPCQT)	TF33	CBE C05	"		41	30	112	25		10	10.6	
NSH	98021A	35	CTE C05										
PII													
PCII	(MTPCQE)	TF41	CBE E01	"		18	15	26	20		6	10.3	
NSH	98202A	A1											
PII													
PCII	(MTPCQT)	TF33	CBE Y02	"		0	0	0	0		15	3	
NSH	50135A	J57	CBE Y12										
PII		ALL											
PCII	(MTPCQT)	TF33	CBE Y02	"		0	0	0	0		15	5	
NSH	50138A	J57	CBE Y12										
PII		ALL											
PCII	(MTPCQT)	TF33	CBE Y03	"		192	384	336	530		90	5	
NSH	50136A	J57	CBE Y13										
PII		ALL											
PCII	(MTPCQT)	TF33	CBE C06	"		192	384	336	530		90	1.0	
NSH	98031A	7	CTE C06										
PII													
PCII													
NSH													
PII													
PCII													
NSH													
PII													

WORKLOAD PROFILE

Gebreyehu

NAME <u>TATIANA</u>		ALC <u>OCABC</u>		DATE <u>1 MAY 89</u>		RCC <u>MIPCB</u>		SHEET <u>1</u> OF <u>2</u>			
ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER				NO. OF ENVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS
					1	2	3	4			
PCN 49802A HSH PHI	J57 ALL	CBE401 CBE4T1	4	Ø	148	161	137	159		26	22.7
PCN 49806A HSH PHI	J57 ALL	CBE401 CBE4T1	"	f	166	115	163	175		26	22.7
PCN 49808A HSH PHI	J57 ALL	CBE401 CBE4T1	"	f	81	71	100	91		17	22.7
PCN 49810A HSH PHI	J57 ALL	CBE401 CBE4T1	"	f	95	107	69	83		17	22.7
PCN 98034A HSH PHI	TF0033 009	CBE404 CTEC04	"	f	60	58	40	46		10	18.6
PCN 98042A HSH PHI	TF33-7	CBE404 CTEC04	"	f	81	105	63	46		15	19.4
PCN 98043A HSH PHI	TF33-7	CBE404 CTEC04	"	f	87	81	77	54		13	19.4
PCN 98057A HSH PHI	TF0033 009	CBE404 CTEC04	"	f	52	50	40	42		8	18.7
PCN 50134A HSH PHI	TF30 103.7.9	CBE404 CTEC04	"	f	37	43	108	90		18	10.7
PCN 98206A HSH PHI	TF41A1	CBE202 CBE294	"	f	27	25	42	45		6	42.0
PCN 50067A HSH PHI	J19-15/ ITEG	CBE209 CBE230 CBE251	"	f	1100	1035	870	730		170	2.2
PCN 38685A HSH PHI	J19+15 +17	CBE213 CBE214	"	f	92	98	76	118		19	16.6
PCN 38690A HSH PHI	J19 +15	CBE207 CBE208	"	f	32	40	21	15		7	17.7

Schubert

TRCC NTPCB SHEET 2 OF 2
88-1-88-4

ENVELO

(For Internal Use, Not a Model Input)

ALC <u>DC</u>		RCC <u>MAFPAK</u>	EQUIPMENT CODE <u>LS-1178</u>		(PD68C)	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCI NISH PIN	97202	.485	638	1	3	
PCI NISH PIN	97206	.895	1178	1	7	
PCI NISH PIN	97204	.319	420	1	5	
PCI NISH PIN	96515	.335	441	1	5	
PCI NISH PIN	96553	1.86	2448		5	
PCI NISH PIN	96523	1.052	1384		5	
PCI NISH PIN	97150	.561	738		5	
PCI NISH PIN	97178	.481	633		5	
PCI NISH PIN	98021	.481	633		5	
PCI NISH PIN	38625	.565	744		6	
PCI NISH PIN	38690	.908	1195		5	
PCI NISH PIN	37691	.908	1195	1	5	

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 36.413

ENV. 3P

(For Internal Use, Not a Model Input)

ALC <u>QC</u>		RCC <u>MATTEL</u>		EQUIPMENT CODE <u>QC-1178</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>36.413</u>		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM				
PCN NSN P/N	38644	.028	37	1	20				
PCN NSN P/N	50067	.05	66	1	20				
PCN NSN P/N	50135	.00076	1	1	48	MIN. VALUE			
PCN NSN P/N	50138	.00076	1	1	48				
PCN NSN P/N	50136	.00076	1	1	48				
PCN NSN P/N	98031	.00076	1	1	48	↓			
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									

(For Internal Use, No. a Model Input)

3

ALC <u>DC</u>		RCC <u>11A1R-23</u>		EQUIPMENT CODE <u>DC 3019 (40-20A-2)</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>31.543</u>		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM					
PCN NSN P/N 38644	.028	37	1	30					
PCN NSN P/N 50064	"	—	1	30					
PCN NSN P/N 50135	.00076	1	48	192					
PCN NSN P/N 50136	.00076	1	48	192					
PCN NSN P/N 50138	.00076	1	48	192					
PCN NSN P/N 93031	.00076	1	48	192					
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									

ENVELOP

(For Internal Use, Not a Model Input)

ALC <u>OC</u>		RCC <u>NAT PCH</u>	EQUIPMENT CODE <u>OC</u>		<u>3020 (ALFA line)</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>31.5 ft³</u>	
LIST OF PARTS BY ITEM NUMBER	SIZE VOLUME CU. FT.	UNIT VALUE	AVERAGE	MAXIMUM	REMARKS	SOURCE		
(PCI) 96523 IISH P/H	1.052	1384	1	20				
(PCI) 38644 IISH P/H	.028	37	1	30				
(PCI) 50067 IISH P/H	.05	.66	1	30				
(PCI) 50135 IISH P/H	.00076	1	48	192				
(PCI) 50136 IISH P/H	.00076	1	48	192				
(PCI) 50138 IISH P/H	.00076	1	48	192				
(PCI) 50139 IISH P/H	.00076	1	48	192				
(PCI) IISH P/H								
(PCI) IISH P/H								
(PCI) IISH P/H								
(PCI) IISH P/H								
(PCI) IISH P/H								
(PCI) IISH P/H								

ENVELO

(For Internal Use, Not a Model Input)

ALC <u>8C</u>		RCC <u>MAT PCH</u>		EQUIPMENT CODE <u>CC-3001</u> (ALKALINE)		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>31.542</u>	
LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	APPROX	MAXIMUM	REMARKS/SOURCE		
<u>96523</u> PCI HSR PHI	1.052	1384	1	20			
<u>50004</u> PCI HSR PHI	.028	37	1	30			
<u>50027</u> PCI HSR PHI	.050	608	1	30			
<u>50133</u> PCI HSR PHI	.00076	1	48	192			
<u>50136</u> PCI HSR PHI	.00076	1	48	192			
<u>50138</u> PCI HSR PHI	.00076	1	48	192			
<u>98031</u> PCI HSR PHI	.00076	1	48	192			
<u> </u> PCI HSR PHI							
<u> </u> PCI HSR PHI							
<u> </u> PCI HSR PHI							
<u> </u> PCI HSR PHI							
<u> </u> PCI HSR PHI							
<u> </u> PCI HSR PHI							

ENVELO

(For Internal Use, Not a Model Input)

ALC <u>OC</u>		RCC <u>RAFT PCH</u>	EQUIPMENT CODE <u>OC-3022</u> (<u>PERMANENT</u>)		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>31.5 ft³</u>	
LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE	
(PCI) ISH PII 28644	.028	1384	1	30		
(PCI) ISH PII 50067	.05	658	1	30		
(PCI) ISH PII 50135	.00076	1	48	192		
(PCI) ISH PII 50136	.00076	1	48	192		
(PCI) ISH PII 50138	.00076	1	48	192		
(PCI) ISH PII 50031	.00076	1	48	192		
(PCI) ISH PII						
(PCI) ISH PII						
(PCI) ISH PII						
(PCI) ISH PII						
(PCI) ISH PII						
(PCI) ISH PII						
(PCI) ISH PII						
(PCI) ISH PII						

ENV-220p

(For Internal Use, No. a Model Input)

7

ALC <u>00</u>		RCC <u>DATA</u>	EQUIPMENT CODE <u>00 3022</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>31.5413</u>		REMARKS/SOURCE
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM		
PCN NBN P/N	<u>38644</u>	<u>.028</u>	<u>1384</u>	<u>1</u>	<u>30</u>		
PCN NSN P/N	<u>50067</u>	<u>.105</u>	<u>658</u>	<u>1</u>	<u>30</u>		
PCN NSN P/N	<u>50135</u>	<u>.00076</u>	<u>1</u>	<u>48</u>	<u>192</u>		
PCN NSN P/N	<u>50136</u>	<u>.00076</u>	<u>1</u>	<u>48</u>	<u>192</u>		
PCN NSN P/N	<u>50138</u>	<u>.00076</u>	<u>1</u>	<u>48</u>	<u>192</u>		
PCN NBN P/N	<u>98031</u>	<u>.00076</u>	<u>1</u>	<u>48</u>	<u>192</u>		
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							

ENV-27P

(For Internal Use, Not a Model Input)

8

ALC <u>DC</u>		RCC <u>MATICS</u>		EQUIPMENT CODE <u>DC 3024</u>		PERMANENT	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE	
PCN NSN PIN	38644	.028	1384	1	30		
PCN NSN PIN	50067	.105	658	1	30		
PCN NSN PIN	50135	.00076	1	48	192		
PCN NSN PIN	50138	.00076	1	48	192		
PCN NSN PIN	50136	.00076	1	48	192		
PCN NSN PIN	98031	.00076	1	48	192		
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							

LSC-20106A

72 f93

LIST OF PARTS BY ITEM NUMBER

PCN
NSN
P/M

38644

1.028

—

40

PCN NSN P/M

50067

50.

2

—

05

PCH **MSN** **P/W**

PCH **MSN** **P/W**

PCN MSN P/M

PCN MSN P/M

PCN MSN P/M

PCN
HSM
P/M

PCN
HSM
P/M

PCN
HSM
P/M

PCN
NSN
P/M

PCN
NSN
P/M

PCN
NSN
P/M

PCN HSN P/M

PCN HSN P/M

PCN HSN P/M

PCN HSN PM

PCN HSN PM

PCN HSN PM

PCN HSN DAI

PCN HSN DAI

PCN HSN DAI

PCN	MSM	Age
-----	-----	-----

PCN	MSM	Age
-----	-----	-----

PCN	MSM	Age
-----	-----	-----

PCN
MSN
PM

PCN
MSN
PM

PCN
MSN
PM

PCN
MSH
DPM

PCN
MSH
DPM

PCN
MSH
DPM

1

1

1

(For Internal Use, Not a Model Input)

ALC

RCC 220713B

EQUIPMENT CODE 00 3331 (Permanusa)

72-49-3

[illegible]

LSJ-2011K-A

ENTRE

(For Internal Use, Not a Model Input)

[illegible]

AKA Inc

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 72 f73

[illegible]

ENVELOP

(For Internal Use, No. a Model Input)

14

ALC <u>OC</u>		RCC <u>UNITED</u>		EQUIPMENT CODE <u>OC 338 (PERMANENT)</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>72.73</u>		REMARKS/SOURCE
LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM				
PCN NSN P/N 49802	2.48	1	1	2				
PCN NSN P/N 49806	2.48	1	1	2				
PCN NSN P/N 49808	2.48	1	1	2				
PCN NSN P/N 49810	2.48	1	1	2				
PCN NSN P/N 49812	2.48	1	1	2				
PCN NSN P/N 98032	2.48	1	1	2				
PCN NSN P/N 98043	2.48	1	1	2				
PCN NSN P/N 98051	2.48	1	1	2				
PCN NSN P/N								
PCN NSN P/N								
PCN NSN P/N								
PCN NSN P/N								
PCN NSN P/N								
PCN NSN P/N								

(For Internal Use, No. a Model Input)

ALC 00

ACC

17

EQUIPMENT CODE

000000

大

72
TOTAL VOLUME OF EQUIPMENT IN CU. FT.

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 49802	2.48	1	1	2	
PCN NSN P/N 49806	2.48	1	1	2	
PCN NSN P/N 49808	2.48	1	1	2	
PCN NSN P/N 49810	2.48	1	1	2	
PCN NSN P/N 49812		1		2	
PCN NSN P/N 49813	2.48	1	1	2	
PCN NSN P/N 49815	2.48	1	1	2	
PCN NSN P/N 49817	2.48	1	1	2	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

ENV-2100

(For Internal Use, Not a Model Input)

16

ALC <u>OC</u>		RCC <u>MA7P23</u>		EQUIPMENT CODE <u>OC 3347 (ALBA Line)</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>72 ft³</u>	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE	
PCN NSN P/N	38644	.028	1	1	40		
PCN NSN P/N	50067	.05	2	1	40		
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							
PCN NSN P/N							

ENV-20P

(For Internal Use, No. a Model Input)

17

ALC <u>00</u>		RCC <u>PIAT 202</u>		EQUIPMENT CODE <u>00 3348</u> (<u>Perman. 1470</u>)		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>72</u>		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM				
PCN NSN PIN	49802	2.48	1	1	2				
PCN NSN PIN	49806	2.48	1						
PCN NSN PIN	49808	2.48	1						
PCN NSN PIN	49810	2.48	1						
PCN NSN PIN	98034	2.48	1						
PCN NSN PIN	98035								
PCN NSN PIN	98043	2.48	1						
PCN NSN PIN	98057	2.48	1						
PCN NSN PIN									
PCN NSN PIN									
PCN NSN PIN									
PCN NSN PIN									

ENV-ELOP

(For Internal Use, No. a Model Input)

18

ALC		RCC		EQUIPMENT CODE		TOTAL VOLUME OF EQUIPMENT IN CU. FT.		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM				
PCN NSN P/N	49802	2.48	1	1	2				
PCN NSN P/N	49806	2.48	1	1	2				
PCN NSN P/N	49808	2.48	1	1	2				
PCN NSN P/N	49810	2.48	1	1	2				
PCN NSN P/N	98032								
PCN NSN P/N	98034	2.48	1	1	2				
PCN NSN P/N	98043	2.48	1	1	2				
PCN NSN P/N	98057	2.48							
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									

ENV-20106A

(For Internal Use, No. a Model Input)

19

ALC <u>00</u>		RCC <u>MARK B</u>		EQUIPMENT CODE <u>003350 (Mark B Lines)</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>72</u>		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM				
PCN NSN P/N	49802	2.48	1	1	2				
PCN NSN P/N	49806	2.48	1	1	2				
PCN NSN P/N	49808	2.48	1	1	2				
PCN NSN P/N	49810	2.48							
PCN NSN P/N	98032								
PCN NSN P/N	98034	2.48							
PCN NSN P/N	98043	2.48							
PCN NSN P/N	98057	2.48							
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									

ENV 200

(For Internal Use, No. a Model Input)

20

ALC <u>OC</u>		RCC <u>WAPCB</u>		EQUIPMENT CODE <u>013351 (P)</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>72</u>		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM				
PCN NSN P/N	47802	2.48	1	1	2				
PCN NSN P/N	49806	2.48	1	1	2				
PCN NSN P/N	49808	2.48	1	1	2				
PCN NSN P/N	49810	2.48	1	1	2				
PCN NSN P/N	98032								
PCN NSN P/N	98034	2.48	1	1	2				
PCN NSN P/N	98043	2.48	1	1	2				
PCN NSN P/N	98051	2.48	1	1	2				
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									

ENVELOP

(For Internal Use, No. a Model Input)

ALC <u>CC</u>		RCC <u>UNITED</u>	EQUIPMENT CODE <u>CC 4132 Cold Water</u>		TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>3.5 ft³</u>		REMARKS/SOURCE
LOT OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM			
PCN NSN PIN <u>38644</u>	<u>.028</u>	<u>37</u>		<u>2000</u>			
PCN NSN PIN <u>50064</u>	<u>.055</u>	<u>66</u>	<u>1</u>	<u>2000</u>			
PCN NSN PIN <u>50135</u>	<u>.00076</u>	<u>1</u>	<u>48</u>	<u>192</u>			
PCN NSN PIN <u>50138</u>	<u>.00076</u>	<u>1</u>	<u>48</u>	<u>192</u>			
PCN NSN PIN <u>50136</u>	<u>.00076</u>	<u>1</u>	<u>48</u>	<u>192</u>			
PCN NSN PIN <u>98031</u>	<u>.00076</u>	<u>1</u>	<u>48</u>	<u>192</u>			
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							
PCN NSN PIN							

ENVELOP

(For Internal Use, No. a Model Input)

22

ALC		RCC		EQUIPMENT CODE		TOTAL VOLUME OF EQUIPMENT IN CU. FT.		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.		UNIT VALUE		MINIMUM		MAXIMUM	
PCN NSN P/N	38644	.028	37	1	2000				
PCN NSN P/N	50064	X							
PCN NSN P/N	50135	.00076	1	48	192				
PCN NSN P/N	50138	.00076	1	48	192				
PCN NSN P/N	50136	.00076	1	48	192				
PCN NSN P/N	99031	.00076	1	48	192				
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									

ENVELOP

(For Internal Use, No. a Model Input)

ALC		RCC		EQUIPMENT CODE		TOTAL VOLUME OF EQUIPMENT IN CU. FT.		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM				
PCN NSN P/N	38644	.028	37	1	2000				
PCN NSN P/N	50064	.00076	1	1	20				
PCN NSN P/N	35	.00076	1	48	0.7				
PCN NSN P/N	50138	.00076	1	48	192				
PCN NSN P/N	50136	.00076	1	48	192				
PCN NSN P/N	98031	.00076	1	48	192				
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									
PCN NSN P/N									

ENVIRONMENTAL

(For Internal Use, No. a Model Input)

ALC

RCC

EQUIPMENT CODE

4137 (TRUCK)

TOTAL VOLUME OF EQUIPMENT IN CU. FT.

3.5473

LIST OF PARTS BY ITEM NUMBER

SIZE/VOLUME CU. FT.

UNIT VALUE

MINIMUM

MAXIMUM

REMARKS/SOURCE

PCN

NSN

P/N

38644

.028

1

20

PCN

NSN

P/N

50067

.05

2

20

PCN

NSN

P/N

PCN

NSN

P/N

PCN

NSN

P/N

PCN

NSN

P/N

PCN

NSN

P/N

PCN

NSN

P/N

PCN

NSN

P/N

PCN

NSN

P/N

PCN

NSN

P/N

PCN

NSN

P/N

LSC-20106A

(For Internal Use, Not a Model Input)

ALC OC

RCC.

RCC DATA

EQUIPMENT CODE

4140 HOT WATER

TOTAL VOLUME OF EQUIPMENT IN CU. FT.

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NBH PIN 38644	.028	37	1	20	
PCN NSH PIN 50067	.05	66	1	20	
PCN NSH PIN 50135	.00076	1	48	192	
PCN NSH PIN 50136	.00076	1	48	192	
PCN NSH PIN 50138	.00076	1	48	192	
PCN NSH PIN 98031	.00076	1	48	192	
PCN NSH PIA					
PCN NSH PIN					
PCN NSH PIN					
PCN NSH PIN					
PCN NSH PIA					
PCN NSH PIN					
PCN NSH PIN					
PCN NSH PIN					
PCN NSH PIN					

ENVELO

(For Internal Use, Not a Model Input)

ALC	RCC	EQUIPMENT CODE	TOTAL VOLUME OF EQUIPMENT IN CU. FT.			
8C	NAT PCH	OC 4947	7543			
LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE	
PCI ISH PHI 381598	.908	1194	1	1		
PCI ISH PHI 381591	.908	1194	1	2		
PCI ISH PHI 381525	.565	743	1	2		
PCI ISH PHI 561324	.319	420	1	2		
PCI ISH PHI 96515	.335	441	1	2		
PCI ISH PHI 965533	1.052	1384		2		
PCI ISH PHI 965533	1.86	2435		2		
PCI ISH PHI 9750	.561	738		2		
PCI ISH PHI 9750	.481	633		2		
PCI ISH PHI 98021	.481	633				
PCI ISH PHI 975066	.895	1178		1		
PCI ISH PHI						

(For Internal Use, not a Model Input)

ALC OC RCC MATERS EQUIPMENT CODE OC 4947 down-in

EQUIPMENT CODE

RCC MATTCB

1

ALC OC

TOTAL VOLUME OF EQUIPMENT IN CU. FT.

REMARKS/SOURCE

[illegible]

ENV OP

(For Internal Use, not a Model Input)

ALC DC RCC MATLB EQUIPMENT CODE 00 6025 (mag.)TOTAL VOLUME OF EQUIPMENT IN CU. FT. 10,47 ft³

REMARKS/SOURCE

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38685	.565	11	1	5	
PCN NSN P/N 38690	.908	18	1	5	
PCN NSN P/N 38691	.908	18	1	5	
PCN NSN P/N 50067	.05	1	1	60	visual
PCN NSN P/N 50134	.319	6	1	5	
PCN NSN P/N 96515	.335	7	1	5	
PCN NSN P/N 96523	.335	7	1	5	
PCN NSN P/N 96555	1.86	37	1	5	
PCN NSN P/N 98202	.485	10	1	5	
PCN NSN P/N 98206	.895	18	1	1	
PCN NSN P/N					
PCN NSN P/N					

ENV OP

(For Internal Use, not a Model Input)

ALC OL RCC RAIPB EQUIPMENT CODE OL 0229 (3001) 2121 30TOTAL VOLUME OF EQUIPMENT IN CU. FT. 13.23 1 of 2

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 38685	.565	11	1	(supplies) 60	
PCN NSN P/N 38690	.908	18	1	60	
PCN NSN P/N 38691	.908	18	1	60	
PCN NSN P/N 49802	2.48	50	1	2	
PCN NSN P/N 49806	2.48	50	1	2	
PCN NSN P/N 49808	2.48	50	1	2	
PCN NSN P/N 49810	2.48	50	1	2	
PCN NSN P/N 50067	.05	1	1	60	
PCN NSN P/N 98042	2.48	50	1	2	
PCN NSN P/N 98043	2.48	50	1	2	
PCN NSN P/N 98057	2.48	50	1	2	
PCN NSN P/N 98058	.805	18	1	1	

ENV OP

(For Internal Use, not a Model Input)

ALC		RCC		EQUIPMENT CODE		TOTAL VOLUME OF EQUIPMENT IN CU. FT.		REMARKS/SOURCE	
LIST OF PARTS BY ITEM NUMBER		SIZE/VOLUME CU. FT.		UNIT VALUE		MINIMUM		MAXIMUM	
PCN	50134	.319	6	1	6				
NSN	96523	1.052	21	1	6				
P/N	98034	2.48	50	1	2				
PCN									
NSN									
P/N									
PCN									
NSN									
P/N									
PCN									
NSN									
P/N									
PCN									
NSN									
P/N									
PCN									
NSN									
P/N									
PCN									
NSN									
P/N									
PCN									
NSN									
P/N									

ENV. DP

(For Internal Use, Not a Model Input)

ALC <u>OC-ALC</u>		RCC <u>MATC B</u>		EQUIPMENT CODE <u>OC 3338, 3348, 3346, 3351,</u>	
TOTAL VOLUME OF EQUIPMENT IN CU. FT. <u>3350, 3349</u>					
LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN 98057A NSN 98057A PIN 98057A			1	2	POTASSIUM CHROMATE AND SODIUM HYDROXIDE TANKS USED IN CLEANING MANIFOLDS
PCN					
NSN					
PIN					
PCN					
NSN					
PIN					
PCN					
NSN					
PIN					
PCN					
NSN					
PIN					
PCN					
NSN					
PIN					
PCN					
NSN					
PIN					
PCN					
NSN					
PIN					
PCN					
NSN					
PIN					

ENV. 3P

(For Internal Use, Not a Model Input)

ALC OC-ALC

RCC MATCBE

EQUIPMENT CODE OC 3338, 3348, 3346, 3351,

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 3350, 3349

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N 980434 980434			1	2	POTASSIUM CHROMATE AND SODIUM HYDROXIDE TANKS USED IN CLEANING MANIFOLDS
PCN					
NSN					
P/N					
PCN					
NSN					
P/N					
PCN					
NSN					
P/N					
PCN					
NSN					
P/N					
PCN					
NSN					
P/N					
PCN					
NSN					
P/N					
PCN					
NSN					
P/N					
PCN					
NSN					
P/N					
PCN					
NSN					
P/N					

(For Internal Use, Not a Model Input)

[illegible]

OPERATION PROFILE

NAME <u>E. Totten</u> ALC <u>OC</u> DATE <u>5/2/89</u> RCC <u>MAT PCB</u> SHEET <u>1</u> OF <u>6</u>		WCD <u>CBEM19</u> WCD DATE <u>88180</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MANPOWER SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
00	MAT	IN	1.0	TRANSIT	1.0 24							
	PCB			SETUP								
				PROCESS								
1		REC	.70	TRANSIT								unc rate, pw
				SETUP								
				PROCESS								
10		PW	1.0	TRANSIT		APO9	1	1.0 2.0	BEN 1	1	1.0 2.0	
				SETUP								
				PROCESS								
15		CLN	1.0	TRANSIT			1	1.0 .25	BEN 1	1	1.0 .25	degrade
				SETUP								
				PROCESS			1	1.0 .10	OC 4947	1	1.0 .10	
16		PROC	1.0	TRANSIT								cool
				SETUP								
				PROCESS	1.0 .40		1	1.0 .10	OC 4947	1	1.0 .10	

OPERATION PROCEDURE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 6

WCD CBEM19		WCD DATE																	
OPERATION NUMBER	RC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INHOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS					
					%	HRS.		QTY.	HRS.	QTY.	HRS.	%	HRS.						
17	MAH PCB	CLN	1.0	TRANSFER	-	-	AP09	1	1.0	50	1	OC 4137	1.0	50					
				SETUP	-	-										PROCESS	-	-	
18		CLN	1.0	TRANSFER	-	-			1	1.0	10	OC 4561	1	1.0	10				
				SETUP	-	-											PROCESS	-	-
19		CLN	1.0	TRANSFER	-	-			1	1.0	10	OC 1174	1	1.0	10				
				SETUP	-	-											PROCESS	-	-
20		INSP	1.0	TRANSFER	-	-			1	1.0	10	OC BEN1	1	1.0	10				
				SETUP	-	-											PROCESS	-	-
30		INSP	1.0	TRANSFER	-	-			1	1.0	10	OC 4602	1	1.0	10				
				SETUP	-	-											PROCESS	-	-

OPERATION PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET <u>3</u> OF <u>6</u>										
PCII _____		NISH _____		PIL _____		WCD <u>SBEM19</u>		WCD DATE _____										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS								
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	INS.		EQUIPMENT CODE	QTY.	TIME REQUIRED %	INS.				
40	MAT PCB	INSP	1.0	PREPARE	-	-	-	-	-	-								
				SETUP							PROCESS	1.0	.01	Ben 1	1	1.0	.01	
50	MAT PCB	INSP	1.0	PREPARE	-	-	-	-	-	-								
				SETUP							PROCESS	1.0	.01	Ben 1	1	1.0	.01	
150	MAT PCB	INSP	1.0	PREPARE	-	-	-	-	-	-								
				SETUP							PROCESS	1.0	.01	Ben 1	1	1.0	.01	
160	MAT PCB	PRO	.70	PREPARE	-	-	-	-	-	-								
				SETUP							PROCESS	1.0	1.0	.01	Ben 1	1	1.0	.01
170	MAT PCB	CLN	1.0	PREPARE	-	-	-	-	-	-								
				SETUP							PROCESS	1.0	.01	Ben 1	1	1.0	.01	

OPERATION PROC LE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 4 OF 6					
PCII		HSH		PIL		WCD CBE M 19		WCD DATE					
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAINTENANCE		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	%	HRS.	QTY.		%	HRS.
180	MAT	PROC	1.0	TRANSFER									
	SETUP												
	PROCESS			1.0	1.0								
190	MAT	PROC	1.0	TRANSFER									
	SETUP												
	PROCESS			-	-	AP09	1	1.0	1.0	4602	1	1.0	1.0
200	MAT	PROC	.01	TRANSFER									
	SETUP												
	PROCESS			1.0	.50								
210	MAT	NDI	1.0	TRANSFER									
	SETUP												
	PROCESS			1.0	.30								
220	PIW	INSP	.001	TRANSFER									
				SETUP									
				PROCESS	1	1.0							

OPERATION PRILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 5 OF 6			
PCN _____		PCN _____		PCN _____		PCN _____		PCN _____			
PHI _____		PHI _____		PHI _____		PHI _____		PHI _____			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % INH.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % INH.	EQUIPMENT CODE QTY.	TIME REQUIRED % INH.	DATA SOURCE COMMENTS
230	MAT PIW	REP	1.001	PROCESS	1.0 10						
240	MAT PCB	CLN	1.0	PROCESS	1.0 10						
245	MAT PCB	INSP	1.0	PROCESS							
251	MAT PCB	TEST	1.0	PROCESS							
260	MAT PCB	REC	1.0	PROCESS							

DONE

FLOW PROCESS CHART

SUBJECT J79-15/17 MAIN FUEL NOZZLE, REGULAR CHECK TEST DATE 5/2/89

ITEM CODE

PCN
NBN
PMWCD CBE119WCD DATE 88180

38644 A

J79 JET ENGINE MAIN
FUEL NOZZLE, REGULAR
SOURCE: DAVID MYRICK

(CHART BEGINS)

(CHART ENDS)

PREPARED BY E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
81		●○○□▽	RECEIVE NOZZLES IN BLOC 3123 FM SUPPLY			○○○□▽	
85		○●○○□▽	MOVE NOZZLES FROM BLOC 3123 TO 3AN SHOP			○○○□▽	
810	810	●○○□▽	RECEIVE NOZZLES IN SHOP, SEPARATE TRAY.			○○○□▽	
815	815	●○○□▽	CLEAN NOZZLES IN DECONTAINER			○○○□▽	
816		○●○○□▽	WAIT FOR NOZZLES TO COOL AFTER DECONTAINING			○○○□▽	
817		●○○□▽	CLEAN NOZZLES IN FROTH TANK			○○○□▽	
818		●○○□▽	PLACE NOZZLES IN BOXES OF FUEL W/IN TANKS AND			○○○□▽	
819		●○○□▽	CLEAN NOZZLES W/ GUES BOND AND FLUXER			○○○□▽	
820	820	○○○□▽	INSPECT NOZZLES FOR POUR, ETC.			○○○□▽	
830	830	○○○□▽	INSPECT NOZZLE ALIGNMENT			○○○□▽	
840	840	○○○□▽	REMOVE AND GAP BETWEEN SHROUD & MAIN NOZZLE			○○○□▽	
850	850	○○○□▽	VISUALLY INSPECT WELDING SUB NOY			○○○□▽	
150	150	○○○□▽	VISUALLY INSPECT AROUND NOZZLES FOR GALLING			○○○□▽	
160	160	●○○□▽	REMOVE SHROUDS OF NOZZLES			○○○□▽	
170	170	●○○□▽	CLEAN FUEL FROM NOZZLES IN FROTH			○○○□▽	
180	180	●○○□▽	WELD SHROUDS			○○○□▽	
190	190	○○○□▽	INSPECT SHROUD W/IN GUN GAGE			○○○□▽	
200	200	●○○□▽	GRIND DOWN EXCESS WELD IF REQ.			○○○□▽	
210	210	○○○□▽	VISUALLY INSPECT WELDS			○○○□▽	
220	220	○○○□▽	PERFORM DYE PEN. INSPECTION IF REQ.			○○○□▽	
230	230	●○○□▽	REPAIR CRACKS AS NECESSARY			○○○□▽	
240	240	●○○□▽	CLEAN WORK AREA AFTER WELDING			○○○□▽	
245		○○○□▽	INSPECT NOZZLE ALIGNMENT			○○○□▽	
250	250	○○○□▽	MOVE NOZZLES TO BLOC 3108 FOR TEST			○○○□▽	
251		●○○□▽	PERFORM FLOW TEST, SAFETY WIRE			○○○□▽	
255	255	○○○□▽	REMOVE NOZZLES FROM TEST AREA			○○○□▽	
260	260	●○○□▽	RECEIVE FROM TEST, SEPARATE NOZZLES BY DISC.			○○○□▽	
265	265	●○○□▽	PAINT SHROUD OR TELLER STAMP NR. PART NO.			○○○□▽	
275	275	●○○□▽	COMPLETE AFID 349			○○○□▽	
280	280	●○○□▽	PAPERWORK SIGN OFF			○○○□▽	
290	290	●○○□▽	PAPERWORK SIGN OFF			○○○□▽	
295	295	●○○□▽	PAPERWORK - SELL			○○○□▽	

○ OPERATION

◇ TRANSPORTATION

▽ STORAGE

D DELAY

□ INSPECTION

LSC-20147

"IN" DATES PROC 'LE

NAME _____		ALC <u>OC-ALC</u>	DATE <u>31 MAR 197</u>	PCC <u>MTPC B</u>	SHEET <u>1</u> OF <u>1</u>
PCN HSH PH	OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	PARENT WCD	PARENT WCD DATE	Δ TIME (DATE)
	38644A ✓				
1	8333	8333		8333	0
2	8333	8333		8334	24
3	8334	8334		8334	0
4	8347	8347		8348	24
5	9009	9009		9009	0
6	9009	9009		9009	0
7	9009	9009		9010	24
8	9020	9020		9020	0
9	9020	9020		9023	72
10	9020	9020		9023	72
					(24) 24

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING EITERS IN BLOCK 5 OF WCD ON DATE
THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

LSC-20107A

"OUT" DATES PROGRAM

NAME _____		ALC OC ALC		DATE 31 MAY 89	RCC M + P 15	SHEET 1 OF 1
PCI	ISI	PRI	38644A			
LAST OPERATION (COMPLETION DATE)		LAST OPERATION (COMPLETION DATE)		LAST OPERATION (COMPLETION DATE)		
OBSERVATION NUMBER		OBSERVATION NUMBER		OBSERVATION NUMBER		
1	8334	8334	8334	0		
2	8334	8334	8334	0		
3	8340	8340	8341	24		
4	8349	8349	8350	24		
5	9011	9011	9011	0		
6	9012	9012	9013	24		
7	9012	9012	9013	24		
8	9023	9023	9025	48		
9	9024	9024	9025	24		
10	9031	9031	9031	0		

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATION PRC, ILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 6 OF 6				
PCB HSH PHI		WCD <u>C BEMIS</u>		WCD DATE _____		MANIPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		QTY.	TIME REQUIRED		QTY.	TIME REQUIRED	
					%	HRS.		%	HRS.		%	HRS.
265	MAT PCB	PROC	1.0	TRANSFER								
				PROCESS								
				TRANSFER								
299		PWL	1.0	TRANSFER								
				PROCESS								
				TRANSFER								
9999		OUT	1.0	TRANSFER								
				PROCESS								
				TRANSFER								
				TRANSFER								
				PROCESS								
				TRANSFER								
				TRANSFER								
				PROCESS								
				TRANSFER								
				TRANSFER								
				PROCESS								
				TRANSFER								
				TRANSFER								
				PROCESS								
				TRANSFER								

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/16/89 RCC MAT PCB SHEET 1 OF 5

WCD 38644A WCD DATE 8/18/80

PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAINPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
						%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	
38644A	14	MAT PCB	IN DATE	1.0	TRANSIT									
					SETUP									
					PROCESS	100	24							
10			REC	1	TRANSIT									REMOVE NOZZLES FROM CART. PLACE JONES OF 10 OR BATCH 5 / BOX OF TEST STAND
					SETUP									
					PROCESS			DP29	1	100	.1	OC4228	1	100
15			PROC	1	TRANSIT									WALKDOWN BATCH OF 10
					SETUP									REM NOS
					PROCESS						.05	OC4228	1	.05
20			DIS	1	TRANSIT									TIME IS FOR BATCH OF 10
					SETUP									
					PROCESS						.2	OC4228	1	.2
25			INS	1	TRANSIT									INSPECTION QUALITY
					SETUP									BATCH OF 10
					PROCESS									

OPERATIONAL PROFILE

NAME <u>E. TORRES</u>		ALC <u>OC</u>		DATE <u>5/10/89</u>		RCC <u>MATRB</u>		SHEET <u>2</u> OF <u>5</u>				
PCN <u>38644A</u>		WCD <u>CBM 20</u>		VCD DATE <u>8/1/90</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					MANDATORY FLOW HOURS	QTY.	%	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.		%
28	11AT PCB	ASSY	1	TRANSIT								BATCH #10 REWORK FEELING SPIN AND METRIC COARSE
30		LOAD	1	TRANSIT								NO TESTS APPE TESTING INDIVIDUALS INSTALLED IN STAND- TIME IS FOR BATCH OF 10 PARTS
40		TEST	1	TRANSIT								ALL TESTS UP TO LEAK TEST ARE DONE BY SEQUENCE FOR IN. OF 10 P/N ISSUED TEST BATCH 10
50		TEST	1	TRANSIT								BATCH 10 FLOW TESTS
60		TEST	1	TRANSIT								BATCH 10 SPRAY PARAMETER TEST

OPERATION PROFILE

NAME E. TOTTEN ALC BC DATE 5/16/89 RCC 19AT802 SHEET 3 OF 5

PCN 38644A WCD CHEN20 WCD DATE EF830

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.		QTY.	%	HRS.	QTY.	%	HRS.		
70	MAT PUB	TEST	1	TRANSIT										SIXTY ANGLES TEST	
				SETUP											
				PROCESS			DP09	1	100	.33	OC4278	1	100	.33	BATCH 10
80			1	TRANSIT										MARKET SHOW QUANTITY FOR STREAKS.	
				SETUP											
				PROCESS						.1	OC4278	1		.1	
82			1	TRANSIT										STATIC PRODUCE (LAW) TEST	
				SETUP											
				PROCESS						1	OC4278	1		1	
90			1	TRANSIT										INSTALL IN TEST STAND - "80" CHECK (FLOW DIVIDER) CHECK VALVE	
				SETUP											
				PROCESS						.33	OC4278	1		.33	
95		MOVE	1	TRANSIT										REMOVE 107. FM TEST STAND	
				SETUP										INSTALL IN VISE ON BENCH	
				PROCESS				1	1	.1	TBEN1	1		.1	

OPERATION PROFILE

NAME <u>E. TOTTEN</u> ALC <u>OC</u> DATE <u>5/16/89</u> RCC <u>MATRB</u> SHEET <u>4</u> OF <u>5</u>		WCD <u>11 BEN 20</u> WCD DATE <u>8/80</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	QTY.	%	HRS.	QTY.	
100	MATRB	PROC	1	TRANSIT						SAFETY WHILE (NOT DURING 240 S/H STEP 240 OF AND REMAIN)
101		PROC	1	SETUP						REMOVED FROM VISE. OIL FLUSH W/ 1010 OIL
102		PROC	1	PROCESS						21 MIN EA. TO FLUSH X 10 NR.
120		PN	1	TRANSIT						RECAP INLET P/TIP, BRACE 10 NOZZLES IN SHIPPING BOX.
130		PN	1	SETUP						REMOVE

OPERATION PROFILE

NAME <u>E. TOTTEN</u>		ALC <u>OC</u>		DATE <u>5/14/89</u>		RCC <u>MAT PCB</u>		SHEET <u>5</u> OF <u>5</u>				
PCU NSN <u>38644A</u>		WCD <u>CB E21 20</u>		WCD DATE <u>8/10</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.		
135	MAT PCB	PW	1	TRANSIT								PW
				SETUP								
				PROCESS								
140		PW	1	TRANSIT								PW
				SETUP								
				PROCESS								
150		MOVE	1	TRANSIT								NOTE - TO CB 0/4 FOR PART SPOT APPLICATION
				SETUP								
				PROCESS								
1499		OUT DATE	1.0	TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

OPERATION FILE

NAME <u>RANDY L HARPER</u> ALC <u>OC</u> DATE <u>5/31/89</u> RCC <u>HUTPCB</u> SHEET <u>1</u> OF <u>8</u>		PCN <u>38685A</u>		WCD <u>CBEM13</u>		WCD DATE <u>88236</u>							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	QTY.	SKILL CODE/LEVEL	QTY.	%	HRS.	QTY.	
00	MIP (6)	IN DATE	1.0	TRANSIT									
		SETUP											
		PROCESS			24								
010	MIP CR	REC	1.0	TRANSIT									BEN 22 A.T
		SETUP											
		PROCESS											
020	"	OIS	1.0	TRANSIT									BEN 22 A.T
		SETUP											
		PROCESS											
040	"	TEST	1.0	TRANSIT									IF VALUE TEST OK, NO TEST WORK TO BE DONE (MIP) 25% TOTAL 25% MIP 25% MIP 25% MIP 25% MIP 25%
		SETUP											
		PROCESS											
045	"	OIS	.75	TRANSIT									BEN 22 A.T
		SETUP											
		PROCESS											

OPERATION: JFILE

[illegible]

[illegible]

OPERATION FILE

NAME LANDY LARIS ALC ✓ DATE 5/31/89 RCC 8822 SHEET 4 OF 8

PCN		NSN		PIN		38655A		WCD CBEM13		WCD DATE 88236													
OPERATION NUMBER	ICC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		QTY.	TIME REQUIRED		DATA SOURCE COMMENTS						
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE	%	HRS.										
100	MAIP CB	INSP	.75	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	-	-	INSP IS DONE SETUP & VALUE WAS BETTER UNASSERSED. BUN 22 ACT					
				SETUP	-	-	-	-	-	-	-	-	-	-	-	-	-		-				
				PROCESS	-	-	-	BP09	1	-	.08	MAN 21	1	-	.08	-							
110	"	INSP	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	-	-	BUN 22 ACT					
				SETUP	-	-	-	-	-	-	-	-	-	-	-	-	-		-				
				PROCESS	-	-	-	BP09	1	-	.17	MAN 21	1	-	.17	-	-		-				
120	"	INSP	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	-	-	BUN 22 ACT					
				SETUP	-	-	-	-	-	-	-	-	-	-	-	-	-		-	-			
				PROCESS	-	-	-	BP09	1	-	.33	MAN 21	1	-	.33	-	-		-	-			
130	"	INSP	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	-	-	USE SPRING TESTER BUN 22 ACT					
				SETUP	-	-	-	-	-	-	-	-	-	-	-	-	-		-	-			
				PROCESS	-	-	-	BP09	1	-	.08	MAN 21	1	-	.33	-	-		-	-			
140	MAIP CM	MACH	.25	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	-	-	WILL SEND BRACKET INSP CH. 00352128, TO WORKING FOR CARTON. LONG 114 RETRACED.					
				SETUP	-	-	-	-	-	-	-	-	-	-	-	-	-		-	-			
				PROCESS	-	-	-	BP09	1	-	.08	MAN 21	1	-	.33	-	-		-	-			

OPERATION FILE

NAME <u>KAROL HARRIS</u> ALC <u>QC</u> DATE <u>5/31/89</u> RCC <u>MAT PCB</u> SHEET <u>5</u> OF <u>8</u>												
PCN <u>38685A</u> WCD <u>CHEM 13</u> WCD DATE <u>78236</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
160	MAT CB	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	
				PROCESS	-	BP09	1	25	BEN21	1	25	
170	"	PRDC	1.0	TRANSIT	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	
				PROCESS	-	BP09	1	25	JCS135	1	25	
180	"	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	16000, CURE TIME INCLUDED FOR EPOXY
				SETUP	-	-	-	-	-	-	-	BEN22 ALT
				PROCESS	-	24 BP09	1	33	BEN21	1	33	
185	"	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	OP 150 OF WCD OCCURS AT THIS POINT
(150)				SETUP	-	-	-	-	-	-	-	BEN22 ALT
				PROCESS	-	BP09	1	20	BEN21	1	20	
190	"	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	INSTALL SHAF
				SETUP	-	-	-	-	-	-	-	BEN22 ALT
				PROCESS	-	BP09	1	17	BEN21	1	17	

OPERATION FILE

NAME <u>Benit Harris</u>		ALC <u>X</u>	DATE <u>5/31/87</u>	RCC <u>MAINT</u>	SHEET <u>6</u> OF <u>8</u>								
PCN NSH PIN	386850		WCD <u>COEN13</u>		WCD DATE <u>8828</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
						SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED %
200	MATP CB	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	-	BENZ22ACT
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	BP09	1	33	1	33	
210	"	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	-	BENZ22ACT
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	BP09	1	50	1	50	
220	"	INSP	1.0	TRANSIT	-	-	-	-	-	-	-	-	BENZ22ACT
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	BP09	1	08	1	08	
230	"	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	-	BENZ22ACT
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	BP09	1	08	1	08	
240	"	TEST	1.0	TRANSIT	-	-	-	-	-	-	-	-	SPECIAL BENCH DESIGNATED FOR THIS TEST
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	BP09	1	17	1	17	

OPERATION PROFILE

NAME <u>RANDY HARRIS</u> ALC <u>OC</u> DATE <u>5/31/89</u> RCC <u>NAI PCB</u> SHEET <u>7</u> OF <u>8</u>													
PCN <u>38685</u> WCD <u>CBEN13</u> WCD DATE <u>88236</u>													
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.			
250	INTP CB	ASSY	.75	TRANSIT	-	-	-	-	-	-	-	-	BEN22 ACT
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	1	-	1.0	BEN21	1	
260	"	TEST	1.0	TRANSIT	-	-	-	-	-	-	-	-	SAME COMMENTS AS OP 250
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	1	-	.25	BEN21	1	
270	"	ASSY	1.0	TRANSIT	-	-	-	-	-	-	-	-	BEN22 ACT
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	1	-	.17	BEN21	1	
280	"	INSP	1.0	TRANSIT	-	-	-	-	-	-	-	-	MOVE TO BLDG 3108 FOR TEST (SEE WCD BEN14 FOR WORKING) BEN22 ACT
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	1	-	.08	BEN21	1	
290	"	INSP	1.0	TRANSIT	-	-	-	-	-	-	-	-	MOVE TO BLDG 3108 FOR TEST (SEE WCD BEN14 FOR WORKING) BEN22 ACT
				SETUP	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	

OPERATION FILE

NAME <u>KANDY HARRIS</u> ALC <u>OK</u> DATE <u>5/31/87</u> RCC <u>MAIPCB</u> SHEET <u>2</u> OF <u>8</u>											
PCN <u>38685A</u> WCD <u>56H13</u> WCD DATE <u>88236</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	
300	MATP CB	TEST	1.0	TRANSIT	-	-	-	-	-	-	BEN 22 ACT
				SETUP	-	-	-	-	-	-	
				PROCESS	-	-	1	25	BEN 21	1	
310	"	ASSY	1.0	TRANSIT	-	-	-	-	-	-	BEN 22 ACT
				SETUP	-	-	-	-	-	-	
				PROCESS	-	-	1	25	BEN 21	1	
320	"	PW	1.0	TRANSIT	-	-	-	-	-	-	BEN 22 ACT
				SETUP	-	-	-	-	-	-	
				PROCESS	-	-	1	08	BEN 21	1	
340	"	MOVE	1.0	TRANSIT	-	-	-	-	-	-	BEN 22 ACT
				SETUP	-	-	-	-	-	-	
				PROCESS	-	-	1	08	BEN 21	1	
9999	"	OUT	1.0	TRANSIT	-	-	-	-	-	-	BEN 22 ACT
				SETUP	-	-	-	-	-	-	
				PROCESS	-	-	1	08	BEN 21	1	
					24						

FLOW PROCESS CHART

SUBJECT A-B Fuel PumpDATE 5/31/89

ITEM CODE

PCN
NSN
P/NWCD CBEM/3WCD DATE 88236CHART BEGINS 010

CHART ENDS

PREPARED BY R. J. JARRIS

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●○○□▽	RECEIVE PUMP	300	300	●○○□▽	TEST - CLEARANCE
020	020	●○○□▽	DIS VALVE 14.5 IN	310	310	●○○□▽	ASSY - LINES & PARTS
040	040	●○○□▽	LEAKAGE TEST IN VALVE	320	320 330	●○○□▽	PU
045	—	●○○□▽	DIS VALVE IF NEC	340	340	○○○□▽	MOVE TO SUBJECT
050	050	●○○□▽	DIS PUMP			○○○□▽	
060	060	●○○□▽	CLEAN PUMP IN			○○○□▽	
070	070	○○○□▽	INSP PARTS			○○○□▽	
075	—	○○○□▽	MOVE TO - CM IS NECESSARY			○○○□▽	
080	080	○○○□▽	F.P. INP INDUCER			○○○□▽	
090	090 (A.C.D.)	○○○□▽	MAG INSP ON PARTS			○○○□▽	
092	090 (B)	○○○□▽	"			○○○□▽	
095	090 (E)	○○○□▽	"			○○○□▽	
100	100	○○○□▽	INSP ORIFICE			○○○□▽	
110	110	○○○□▽	INSP IMPELLER			○○○□▽	
120	120	○○○□▽	INSP DRIVE SHAFT			○○○□▽	
130	130	○○○□▽	INSP SPRING			○○○□▽	
140	140	○○○□▽	MOVE TO MACH - CM			○○○□▽	
160	160	●○○□▽	ASSY ROTATING PARTS			○○○□▽	
170	170	●○○□▽	BALANCE PARTS			○○○□▽	
180	180	●○○□▽	ASSY PUMP			○○○□▽	
185	150	○○○□▽	ASSY OF PARTS			○○○□▽	
190	190	●○○□▽	ASSY ROTATING PARTS			○○○□▽	
200	200	●○○□▽	INSTR. RETAINERS			○○○□▽	
210	210	●○○□▽	INSTALL PARTS			○○○□▽	
220	220	●○○□▽	CHECK TORQUE			○○○□▽	
230	230	●○○□▽	ASSY CHECK VALVE			○○○□▽	
240	240	●○○□▽	TEST - LEAK CHECK			○○○□▽	
250	250	●○○□▽	ASSY INLET VALVE			○○○□▽	
260	260	●○○□▽	TEST - LEAK CHECK			○○○□▽	
270	270	●○○□▽	INSTR. INLET VALVE			○○○□▽	
280	280	○○○□▽	INSP - TORQUE CHECK			○○○□▽	
290	290	○○○□▽	MOVE TO BU. 3108			○○○□▽	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

□ DELAY

FILE

SHEET 1 OF 1

LSC-2(X)SA

(13) Leakage from the booster reference port shall not exceed 1.4 milliliters per minute.

(14) If inlet valve assembly passes test, mark a letter A on flange as indicated in substep (1)(b) above.

c. Inlet Valve Assembly Disassembly. Disassemble inlet valve assembly as follows:

(1) Remove retaining ring (12). Using 97-321 inlet valve puller (figure 3-3) remove inlet eye and valve seat housing from valve body assembly. Do not remove wear ring (13, figure 3-1) from inlet eye and valve seat housing (14) unless inspection reveals that replacement is necessary. Refer to paragraph 4-2 for replacement procedures. Remove seal ring (15) from housing (14).

WARNING

Springs (40 and 41) exert a combined force of approximately 100 pounds. Restrained piston head (25) when removing screws (26) to prevent physical injury or part damage when removing these parts.

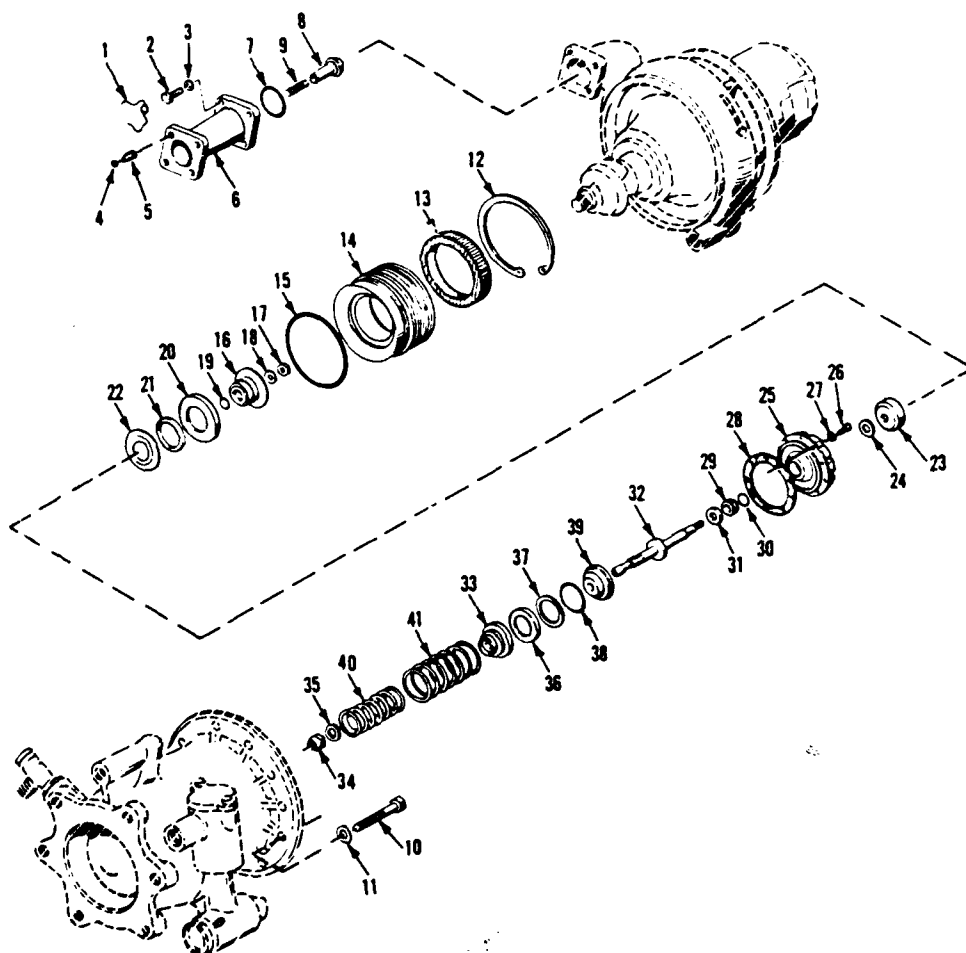
(2) Remove all but 2 diametrically opposite screws (26) and washers (27) with T-1470-E-26 wrench. Install 97-289 valve spring compression fixture (figure 3-4). Compress the assembly and springs (40 and 41, figure 3-1) with an arbor press. Remove the 2 remaining screws (26) and washers (27). Slowly release compression of arbor press and remove the piston rod and head assembly from the valve housing.

(3) Hold piston rod (32) with SF-102-1341-M2 piston rod nut wrench (figure 3-5). Remove locknut (17) and washer (18). Remove seal retainer (16), seal ring (19), diaphragm (20), washer (21), diaphragm spring (22), retainer (23), and spacers (24) from end of piston rod (32). Remove piston head (25) and gasket (28). Remove plug (31) from piston head (25) using SF-102-1341-M1 plug removal puller. Remove Kapseal (29) and seal ring (30) from piston head.

(4) Remove inlet valve piston rod assembly and disassemble. Hold piston rod (32) between contoured wood or Micarta blocks and remove locknut (34), washer (35), piston (33), piston seal (36), seal retainer washer (37), seal ring (38), and seal retainer (39) from piston rod. Remove springs (40 and 41) from valve body (59).

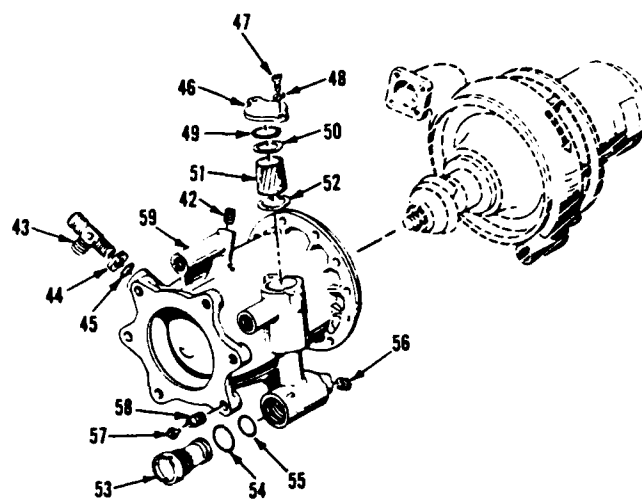
Legend for Figure 3-1

1. Seal	27. Washer	55. Seal ring	82. Ball bearing
2. Bolt	28. Piston head gasket	56. Plug	83. Bearing retainer ring
3. Washer	29. Kapseal	57. Key ring	84. Spacer
4. Key ring	30. Seal ring	58. Insert	85. Belleville spring
5. Insert	31. Plug	59. Valve body	86. Ring
6. Valve housing	32. Piston rod	60. Seal ring	87. Spring retainer
7. Seal ring	33. Inlet valve piston	61. Diffuser	88. Ball bearing
8. Valve	34. Locknut	62. Inducer	89. Drive shaft
9. Spring	35. Washer	63. Locknut	90. Valve seat
10. Bolt	36. Piston seal	64. Washer	91. Seal ring
11. Lock-O-Seal	37. Seal retainer washer	65. Pin	92. Fuel seal retainer
12. Retaining ring	38. Seal ring	66. Impeller	93. Screw
13. Wear ring	39. Seal retainer	67. Impeller shim	94. Diaphragm assembly
14. Inlet eye and valve seat housing	40. Inner spring	68. Belleville spring	95. Spring
15. Seal ring	41. Outer spring	69. Fuel seal disc	96. Oil seal retainer
16. Seal retainer	42. Plug	70. Bearing housing	97. Screw
17. Locknut	43. Tee tube	71. Bolt	98. Diaphragm assembly
18. Washer	44. Nut	72. Washer	99. Key ring
19. Seal ring	45. Gasket	73. Stop retainer	100. Insert
20. Diaphragm	46. Retainer	74. Clamp	101. Key ring
21. Washer	47. Bolt	75. Nut	102. Insert
22. Diaphragm spring	48. Washer	76. Spray nozzle	103. Pin
23. Retainer	49. Seal ring	77. Seal ring	104. Backup washer stop
24. Spacer	50. Belleville spring	78. Seal ring	105. Body wear ring
25. Piston head	51. Filter	79. Retaining ring	106. Body
26. Screw	52. Gasket	80. Oil seal disc	107. Nameplate
	53. Signal flow regulator	81. Seal ring	108. Screw
	54. Gasket		109. Dated decal



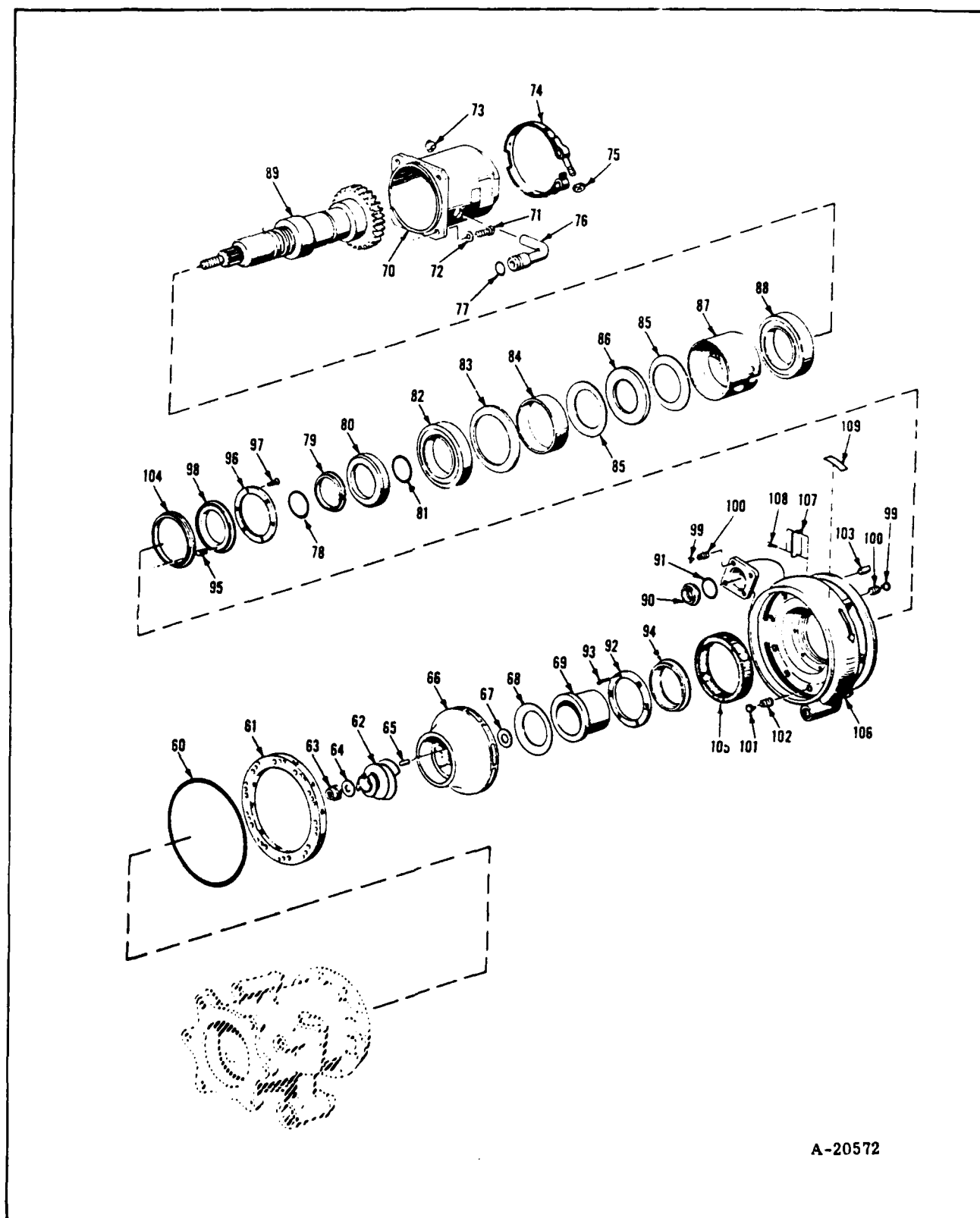
A-19672

Figure 3-1. Exploded View of Afterburner Fuel Pump Assembly (Sheet 1 of 3)



A-20571

Figure 3-1. Exploded View of Afterburner Fuel Pump Assembly (Sheet 2 of 3)



A-20572

Figure 3-1. Exploded View of Afterburner Fuel Pump Assembly (Sheet 3 of 3)

"IN" DATES PROFILE

NAME _____		ALC <u>OC-ALC</u>		DATE <u>31 MAY 89</u>	NCC <u>MTPC B</u>		SHEET <u>1</u> OF <u>1</u>	
PCI	32085H	PARENT WCD		PARENT WCD DATE				
OBSERVATION NUMBER	"II" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)					
1	8 MAY 89		24					
2	8 MAY 89		24					
3	20 JUN 89		24					
4	20 JUN 89		24					
5	22 JUN 89		24					
6	22 JUN 89		24					
			(24)					

NOTE: "II" DATE IS THE DATE THAT SCHEDULING EITERS III BLOCK 5 OF WCD ON DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

"OUT" DATES PROFILE

NAME _____		ALC <u>QC-OLC</u>		DATE <u>31 MAY 89</u>		NCC <u>MT PCB</u>		SHEET <u>1</u> OF <u>1</u>	
PCN _____		PARENT WCD _____		PARENT WCD DATE _____					
PHI _____		PARENT WCD _____		PARENT WCD DATE _____					
OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS)						
1	8312	8312	0						
2	8312	8312	24						
3	8325	8325	0						
4	8312	8312	0						
5	8314	8314	0						
6	8320	8320	0						
			11						

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE NCC.

OPERATION PROFILE

NAME <u>RANDY INERIS</u> ALC <u>OC</u> DATE <u>5/31/89</u> RCC <u>MATPCB</u> SHEET <u>1</u> OF <u>3</u>																						
PCN <u>38685A</u> WCD <u>CBEM14</u> WCD DATE <u>88236</u>																						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS								
						SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.									
00	MATP CB	IN DATE	1.0	TRANSIT	24	-	-	-	-	-	-	-	-	-								
				SETUP												-	-	-	-	-	-	-
				PROCESS																		
010	"	REC	1.0	TRANSIT	-	-	-	-	-	-	-	OC0934 CAN ALSO BE USED FOR THIS PART AS A STAND.										
SETUP	-	-	-	-	-	-	-	-	-	-	-											
PROCESS	-	-	-	BI09	1	100	33	OC4205	1	100	33											
020	"	PROC	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	BEGIN LIBRICATION PROCESS							
				SETUP	-	-	-	-	-	-	-	-	-	-	-							
				PROCESS	-	-	-	BI09	1	02	OC4205	1	33									
030	"	TEST	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-								
				SETUP	-	-	-	-	-	-	-	-	-	-	-							
				PROCESS	-	-	-	BI09	1	50	OC4205	1	50									
040	"	TEST	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-								
				SETUP	-	-	-	-	-	-	-	-	-	-	-							
				PROCESS	-	-	-	BI09	1	58	OC4205	1	58									

OPERATION PROFILE

NAME <u>RANDY HARRIS</u> ALC <u>α</u> DATE <u>5/31/89</u> RCC <u>NAIPCB</u> SHEET <u>2</u> OF <u>3</u>								
PCH <u>38685A</u> WCD <u>CBEN14</u> WCD DATE <u>88236</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER	EQUIPMENT	DATA SOURCE COMMENTS
					%	QTY.	%	
					%	QTY.	%	
050	NAIPCB	TEST	1.0	TRANSIT	-	-	-	
				SETUP	-	-	-	
				PROCESS	-	1	25	25
060	"	TEST	1.0	TRANSIT	-	-	-	
				SETUP	-	-	-	
				PROCESS	-	1	10	10
070	"	TEST	1.0	TRANSIT	-	-	-	
				SETUP	-	-	-	
				PROCESS	-	1	25	25
080	"			TRANSIT	-	-	-	
				SETUP	-	-	-	
				PROCESS	-	-	-	
090	"	PROC	1.0	TRANSIT	-	-	-	
				SETUP	-	-	-	
				PROCESS	-	1	10	10

MECHANIC REPORTS THAT THIS AIR-ARE OVERHAUL IS NEEDED DONE AND WILL BE DELETED FROM NCO SOON. REMOVE PUMP FROM STAND AND FLUSH WITH OIL.

PARALLEL PROCESS PROFILE

NAME RANDY HARELS ALC OC DATE 5/31/89 RCC MATPCB SHEET 1 OF 1

ITEM NUMBER	PARENT WCD	PARENT WCD DATE	BEGINNING OPERATION NUMBER	ENDING OPERATION NUMBER	CHILD PROCESS INFORMATION		
					ITEM NUMBER	CHILD WCD	CHILD WCD DATE
PCN 38685A NSN PIN	CBEM13	88236	070	160	PCN NSN INKNER PIN 02-14548	CBEM13I	88236
PCN 38685A NSN PIN	CBEM13	88236	070	120	PCN NSN DRUG SHAFT PIN 02-13285-02	CBEM13D	88236
PCN 38685A NSN PIN	CBEM13	88236	070	120	PCN NSN IMPELLER PIN 102-1326	CBEM13P	88236
PCN 38685A NSN PIN	CBEM13	88236	070	120	PCN NSN BELLEVILLE SPRING PIN 99-3125	CBEM13B	88236
PCN 38685A NSN PIN	CBEM13	88236	070	190	PCN NSN BELLEVILLE SPRING PIN 02-13828-01	CBEM13H	88236
PCN 38685A NSN PIN	CBEM13	88236	070	250	PCN NSN PISTON ROD PIN 02-13710	CBEM13R	88236
PCN NSN PIN					PCN NSN PIN		
PCN NSN PIN					PCN NSN PIN		
PCN NSN PIN					PCN NSN PIN		
PCN NSN PIN					PCN NSN PIN		
PCN NSN PIN					PCN NSN PIN		
PCN NSN PIN					PCN NSN PIN		
PCN NSN PIN					PCN NSN PIN		

OPERATION PROFILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>060589</u>		RCC <u>MATPCB</u>		SHEET <u>2</u> OF <u>5</u>							
PCN <u>38690A</u>		WCD <u>CBEM07</u>		WCD DATE <u>88236</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT			DATA SOURCE COMMENTS			
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.	
40	MATP CB	INSP	1.0	TRANSIT									INSPECT, REPAIR + RE PLACE AS REQ'D.		
				SETUP											
				PROCESS											
50	MATP CB	NDI	1.0	TRANSIT			AP09	1	100	1.25	BEN14	1	100	1.25	ONLY CEARS (3) + IMPROVE ASSY. TO NOT FOLLOWING MAGNETIC
				SETUP			AP09	1	100	1.2	RELOC	1	100	1.2	
				PROCESS											
60	MATP CB	NDI	1.0	TRANSIT			AP09	1	100	1.3	RELOC	1	100	1.3	FLOR, PEN, INSP.
				SETUP											
				PROCESS											
75	MATP CB	REAM	1.0	TRANSIT										PEAME TAPER PIN HELLS.	
				SETUP											
				PROCESS											
80	MATP CB	ASSY	1.0	TRANSIT			AP09	1	100	1.08	BEN14	1	100	1.08	LASTING BEARING
				SETUP											
				PROCESS											
				TRANSIT			AP09	1	100	1.50	BEN14	1	100	1.50	
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>060589</u>		RCC <u>MATPCB</u>		SHEET <u>3</u> OF <u>5</u>														
PCN <u>38690A</u>		WCD <u>CBEM07</u>		WCD DATE <u>88236</u>																		
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT			DATA SOURCE COMMENTS										
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE		QTY.	%	HRS.							
85	MATP CB	ASSY	1.0	TRANSIT			AP09	1	100	.42	BEN14	1	100	.42	ASSY + LUBC GEAR PUMPING ELEMENT							
				SETUP																		
				PROCESS																		
90	MATP CB	INST.	1.0	TRANSIT			AP09	1	100	.05	BEN14	1	100	.05	INSTALL TAPOR ANS.							
				SETUP																		
				PROCESS																		
100	MATP CB	ASSY	1.0	TRANSIT			AP09	1	100	.25	BEN14	1	100	.25	ASSY IMPERION Housing							
				SETUP																		
				PROCESS																		
105	MATP CB	MOV	1.0	TRANSIT	100	.75	AP09	1	100	.17					TRI QW6 3108 for test							
				SETUP																		
				PROCESS																		
110	MATP CB	ASSY	1.0	TRANSIT			AP09	1	100	.33	BEN14	1	100	.33	ASSY BULLOCK, CHK VALVE RETAINER.							
				SETUP																		
				PROCESS																		

OPERATION 'PROFILE'

NAME <u>P Hunt</u>		ALC <u>OC</u>		DATE <u>060589</u>		NCC <u>MATPCB</u>		SHEET <u>4 of 5</u>			
PCB <u>38690A</u>		WCD <u>CBEM07</u>		WCD DATE <u>88236</u>							
OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.		EQUIPMENT CODE
120	MATP CB	ASSY	1.0	TRANSIT						ASSY RELIEF VALVE ASSY	
				SETUP							
				PROCESS							
130	MATP CB	ASSY	1.0	TRANSIT						ASSY FILTER	
				SETUP							
				PROCESS							
140	MATP CB	ASSY	1.0	TRANSIT						ASSY SEAL	
				SETUP							
				PROCESS							
150	MATP CB	CHK	1.0	TRANSIT						CHK PUMP for fast + easy rotation	
				SETUP							
				PROCESS							
160	MATP CB	MOV	1.0	TRANSIT						from 31CS TEST BENCH	
				SETUP							
				PROCESS							

OPERATION PROFILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>060589</u>		RCC <u>MATPCB</u>		SHEET <u>5</u> OF <u>5</u>					
PCID <u>38690A</u>		WCD <u>CBEM07</u>		WCD DATE <u>88236</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.	QTY.	SKILL CODE/LEVEL	QTY.	EQUIPMENT CODE			
170	MATP CB	WRE	1.0	TRANSIT									SAFETY WIRE + CAP ALL PORTS
				SETUP									
				PROCESS									
180	MATP CB	PW	1.0	TRANSIT									CERTIFY THAT CH IS COMPL.
				SETUP									
				PROCESS									
190	MATP CB	C/W	1.0	TRANSIT									C/W M903 66-36 P12.13
				SETUP									
				PROCESS									
200	MATP CB	MOV	1.0	TRANSIT									MOVE TO SEC OUT
				SETUP									
				PROCESS									
9999	MATP CB	OUT DATE	1.0	TRANSIT									
				SETUP									
				PROCESS									

SUBJECT MAIN FUEL PUMP 30640A DATE 6-05-89

FLOW PROCESS CHART

ITEM CODE
PCH
NSH
P/N

WCD CBEM07 WCD DATE EE236

CHART BEGINS 10 RECEIVE, IDENTIFY + APPROX JAPANESE

CHART ENDS 200 MOVE TO SOL OUT PREPARED BY P.H.W.

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●○○□▽	RECEIVE PU			○○○□▽	
15	—	●○○□▽	CLEAN EXT.			○○○□▽	
20	20	●○○□▽	DIS UNIT			○○○□▽	
30	30	●○○□▽	CLN			○○○□▽	
40	40	○○○□▽	INSP. REPAIR			○○○□▽	
50	50	○○○□▽	NDI, GEARS, IMPELLER			○○○□▽	
60	60	○○○□▽	NDI REST OF UNIT			○○○□▽	
75	75	●○○□▽	REAM PIN HOLE			○○○□▽	
80	80	●○○□▽	INSTALL BEARINGS			○○○□▽	
85	85	●○○□▽	ASM + CL BE GEARS			○○○□▽	
90	90	●○○□▽	INST TAPER PINS			○○○□▽	
100	100	●○○□▽	ASSY IMPELLER HSN6			○○○□▽	
105	105	○○○□▽	MUVE TO 3108 (TEST)			○○○□▽	
110	110	●○○□▽	ASSY BOWTIE			○○○□▽	
120	120	●○○□▽	ASSY RELIEF VALVE			○○○□▽	
130	130	●○○□▽	ASSY FILTER			○○○□▽	
140	140	●○○□▽	ASSY SEAL			○○○□▽	
150	150	○○○□▽	CHK PUMP ROTATION			○○○□▽	
160	160	○○○□▽	PRUN 3102			○○○□▽	
170	170	●○○□▽	SAFETY WIRE UNIT			○○○□▽	
180	180	●○○□▽	PAPERWORK			○○○□▽	
190	190	●○○□▽	COMPLY WITH			○○○□▽	
200	200	○○○□▽	MUVE TO SOL OUT			○○○□▽	
9999	—	●○○□▽	END.			○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	

○ OPERATION

◇ TRANSPORTATION

▽ STORAGE

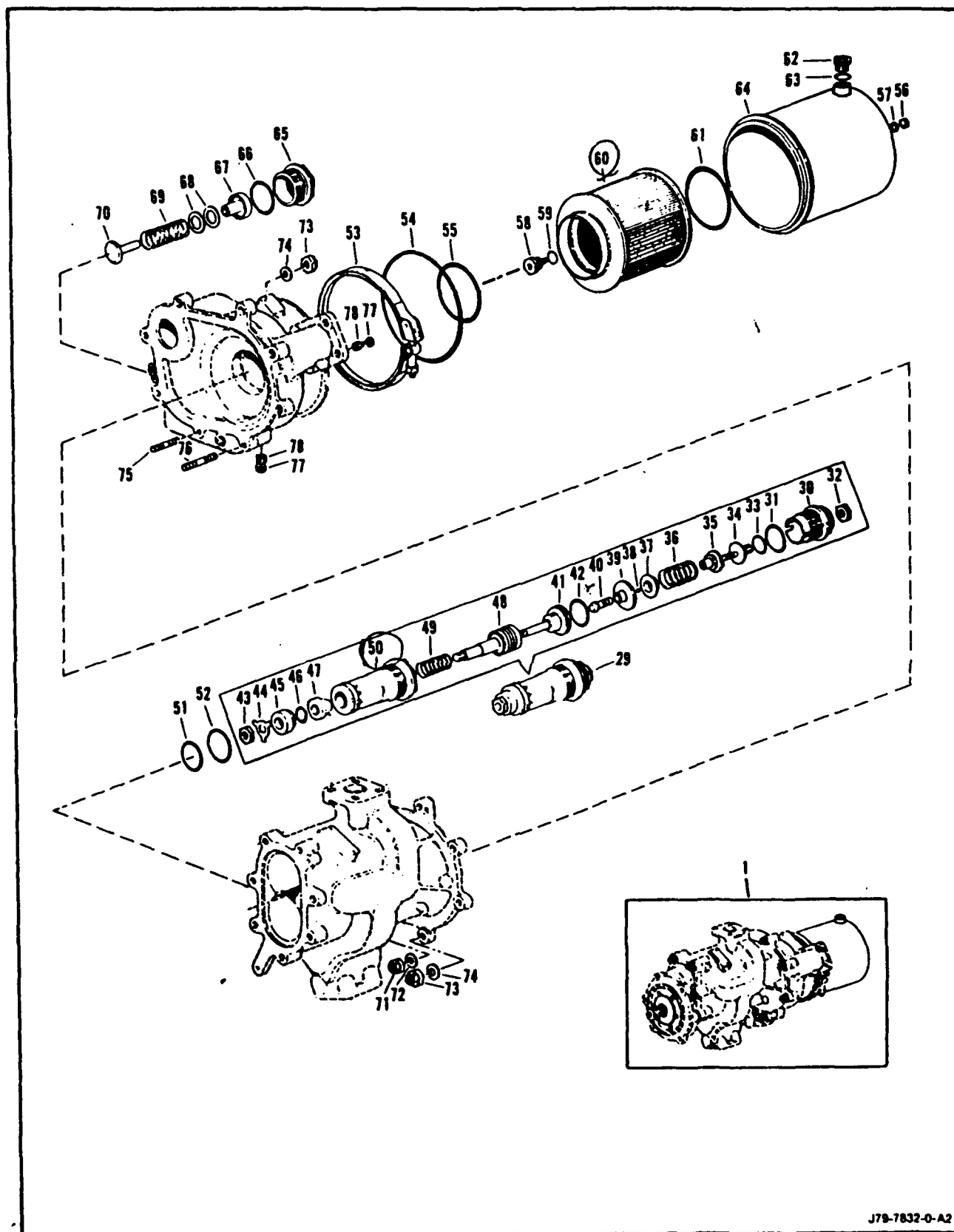
◇ DELAY

□ INSPECTION

LSC-20147

SECTION II
GROUP ASSEMBLY PARTS LIST

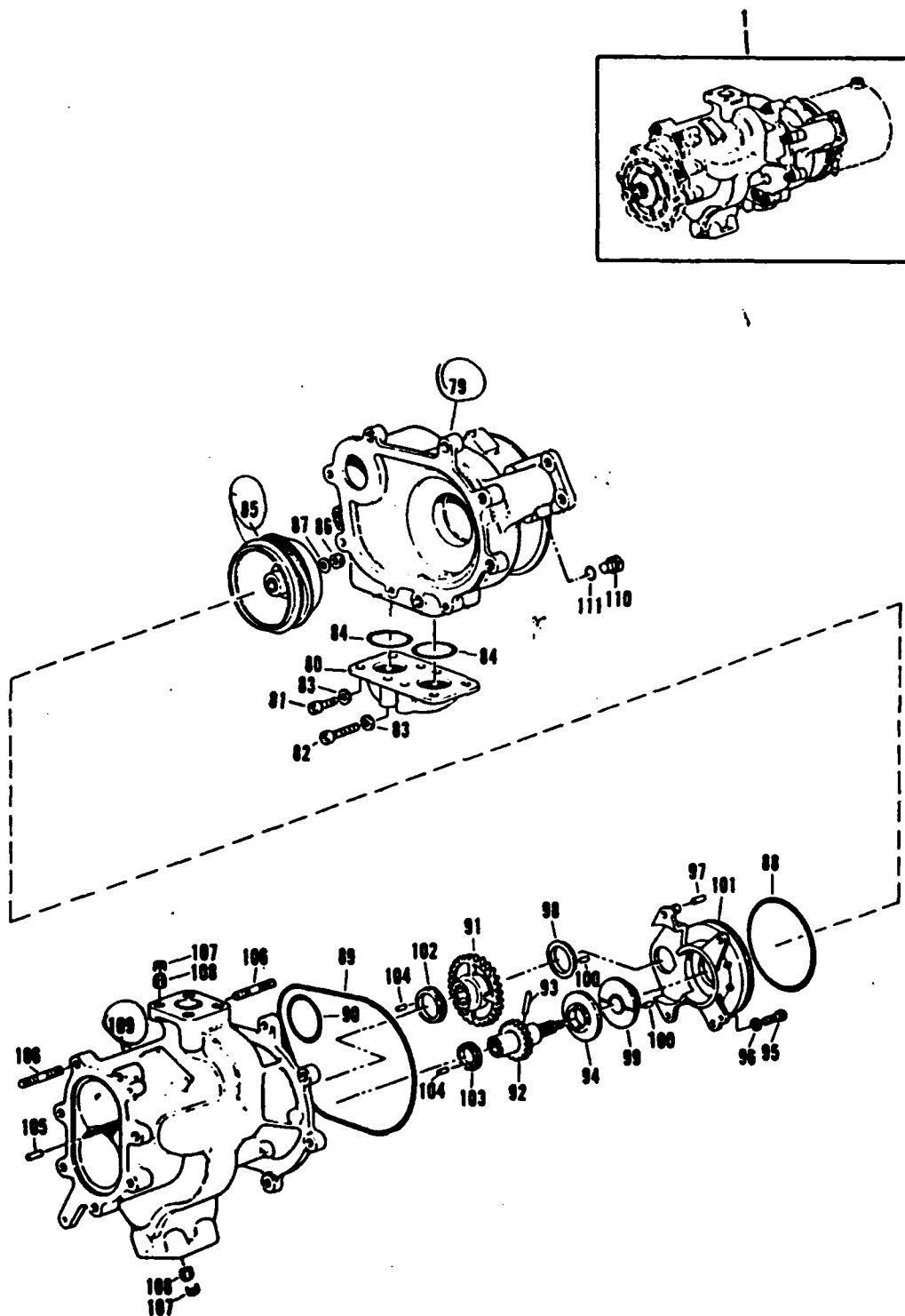
Fig. & Index No.	Part No.	Description							Units Per Assy	Usable On Code
		1	2	3	4	5	6	7		
1-1	024090-019-01	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P6; 07482)							Ref	A
	024090-019-02	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P6; 07482)							Ref	B
	024090-019-05	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P6; 07482)							Ref	C
	024090-019-07	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P6; 07482)							Ref	D
	024090-021-05	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P7; 07482)							Ref	E
	024090-021-07	FUEL PUMP ASSEMBLY, Gear-type with booster . . (99167) (512D892P7; 07482)							Ref	F
-2	02-13423	. PLATE, Thrust (ATTACHING PARTS)							1	
-3	782-22	. SCREW, Socket head -----							6	
-4	99-1924	. SPRING							1	
-5	99-1925	. WASHER							1	
-6	02-13424	. STOP							1	
-7	02-11026	. WASHER							1	
-8	02-11027	. GUIDE							1	
-9	102-847	. SEAL ASSY, Diaphragm							1	
-10	02-13407	. SHAFT, Drive							1	
-11	99-3650	. SPRING							1	
	102-829	. COVER ASSY, Front (ATTACHING PARTS)							1	
-12	99-1240	. PIN, Taper							2	
-13	AN310-5	. NUT							7	
-14	AN960-516	. WASHER -----							7	
-15	PS-112-21-0	. . STUD							1	
	PS-112-21-3	. . STUD (0.003 inch oversize)							1	
	PS-112-21-6	. . STUD (0.006 inch oversize)							1	
-16	02-13398	. COVER, Front							1	
-17	MS29513-240	. RING, Seal							1	
-18	MS29513-125	. RING, Seal							2	A
-19	MS29513-222	. RING, Seal							2	
-20	764-6A	. SPRING							14	
-21	466-12C	. PIN, Seal							1	
-22	02-13655	. BEARING, Cover							1	
-23	02-13654	. BEARING, Cover							1	
	02-13629	. GEARS (matched set)							1	
-24	02-13390	. GEAR, Driven (nonprocureable; see next higher assembly)							1	
-25	02-13389	. GEAR, Drive (nonprocureable; see next higher assembly)							1	
-26	02-13408	. SHAFT, Booster drive							1	
	02-13628	. BEARINGS, Body (matched set)							1	
-27	02-13396	. BEARING, Body (nonprocureable; see next higher assembly)							1	
-28	02-13395	. BEARING, Body (nonprocureable; see next higher assembly)							1	



J79-7832-0-A2

Figure 1. Exploded View of Fuel Pump Assembly (Sheet 2 of 3)

Fig. & Index No.	Part No.	Description							Units Per Assy	Usable On Code
		1	2	3	4	5	6	7		
1-29	102-542	1	
-30	02-12015	1	
-31	MS29513-118	1	
-32	99-2933-01	1	
-33	MS29513-111	1	
-34	02-12233	1	
-35	02-12231	1	
-36	99-2697	1	
-37	02-12232	1	
-38	MS19060-2	1	
-39	02-12230	1	
-40	02-12229	1	
-41	02-12014	1	
-42	MS29513-17	1	
-43	AN316C4R	1	
-44	02-12580	1	
-45	02-12016	1	
-46	MS29513-11	1	
-47	02-12017	1	
-48	02-12013	1	
-49	99-2394	1	
(50)	02-12012	1	
-51	MS29513-118	1	
-52	MS29513-122	1	
-53	58473	1	
	58474	1	
-54	MS29513-255	1	
-55	MS29513-230	1	
-56	MS20364-428C	1	
-57	AN960-416L	1	
-58	02-13464	1	
-59	MS29513-110	1	
(60)	02-13652	1	ABCD
	02-13841	1	ABCD
	118244	1	EF
	7584682	ALT	ABCD
	7584315	ALT	EF
-61	MS29513-230	1	
-62	AN814-4DL	1	
-63	MS29512-04	5	
-64	02-13402	1	
-65	02-13409	1	
-66	MS29512-16	1	
-67	02-13411	1	
-68	AN960C716L	AR	
-69	99-3553	1	
-70	02-13555	1	



J79-7833-0-A2

Figure 1. Exploded View of Fuel Pump Assembly (Sheet 3 of 3)

Fig. & Index No.	Part No.	Description							Units Per Assy	Usable On Code
		1	2	3	4	5	6	7		
.1-	102-910	1	AB
	102-1233-01	1	CDEF
			(ATTACHING PARTS)
-71	AN310-4	1	
-72	AN960-416L	1	
-73	AN310-5	7	
-74	AN960-516	7	
			----
-75	PS111-19-0	1	
	PS111-19-3	AR	
	PS111-19-6	AR	
-76	PS112-21-0	6	
	PS112-21-3	AR	
	PS112-21-6	AR	
-77	99-4011-7	12	AB
	99-4011-7	4	CDEF
-78	933B4SE0562	12	AB
	933B4SE0562	4	CDEF
79	02-13619	1	AB
	02-14806-01	1	CDEF
-80	02-13401	1	AB
			(ATTACHING PARTS)
-81	AN148656	4	AB
-82	AN148675	4	AB
-83	AN960-416L	8	AB
			----
-84	MS29513-126	2	AB
85	02-13650	1	
			(ATTACHING PARTS)
-86	MS20364-428C	1	
-87	AN960-416L	1	
			----
-88	MS29513-234	1	
-89	MS29513-257	1	
-90	MS29513-125	1	
-91	02-13405	1	
-92	02-13406	1	
-93	99-5008	1	
-94	02-13412	1	
	102-836	1	
	102-832	1	
			(ATTACHING PARTS)
-95	99-2506-10-4	4	
-96	AN960C10L	4	
-97	302-15	2	
			----
-98	02-13413	1	
-99	02-13416	1	
-100	99-2350	2	
-101	02-13397	1	
	102-830	1	
-102	02-13413	1	
-103	02-13414	1	

Fig. & Index No.	Part No.	Description							Units Per Assy	Usable On Code
		1	2	3	4	5	6	7		
1-104	99-2350	.	.	.	PIN	.	.	.	2	A
-105	99-908	.	.	.	PIN	.	.	.	1	
-106	PS112-21-0	.	.	.	STUD	.	.	.	7	
	PS112-21-3	.	.	.	STUD (0.003 inch oversize)	.	.	.	AR	
	PS112-21-6	.	.	.	STUD (0.006 inch oversize)	.	.	.	AR	
-107	99-4011-7	.	.	.	RING, Key	.	.	.	8	
-108	933B4SE0562	.	.	.	INSERT (01556) (99-3676; 99167)	.	.	.	8	
-109	02-13404	.	.	.	BODY	.	.	.	1	
-110	AN814-5DL	.	.	.	PLUG	.	.	.	1	
-111	MS29512-05	.	.	.	GASKET	.	.	.	1	
	99-3293	.	.	.	PLATE, Name	.	.	.	1	
		(ATTACHING PARTS)								
	AN500A6-3	.	.	.	SCREW	.	.	.	2	

	02-14124	.	.	.	PLATE, Shipping	.	.	.	2	
	99-3991	.	.	.	GASKET	.	.	.	2	
	MS35304-6	.	.	.	SCREW	.	.	.	6	
	AN960-416L	.	.	.	WASHER	.	.	.	3	
	02-14122	.	.	.	PLATE, Shipping	.	.	.	1	
	AN763-21	.	.	.	GASKET	.	.	.	1	
	AN4047-1	.	.	.	GASKET	.	.	.	1	
	98-312-516-32	.	.	.	SCREW	.	.	.	2	
	99-4385	.	.	.	BLOCK	.	.	.	1	
	99-1987	.	.	.	NUT	.	.	.	2	
	99-204-08	.	.	.	WASHER	.	.	.	4	
	MS35304-5	.	.	.	SCREW	.	.	.	4	
	99-4104-4	.	.	.	PLUG, Shipping	.	.	.	3	
	99-4104-5	.	.	.	PLUG, Shipping	.	.	.	1	

Fig. & Index No.	Part No.	Description							Units Per Assy	Usable On Code
		1	2	3	4	5	6	7		
2-1	024090-014-F1	.	.	.	JIG, Bearing seal pin drill	.	.	.	1	
-2	SF-024090-019-F1	.	.	.	FIXTURE, Pressure test	.	.	.	1	
-3	SF-024090-010-T1	.	.	.	WRENCH, Impeller	.	.	.	1	
-4	T-1144-E	.	.	.	PLUG, Relief valve	.	.	.	1	
-5	97-129-01	.	.	.	FIXTURE, Dowelling	.	.	.	1	
-6	97-129-03	.	.	.	FIXTURE, Dowelling	.	.	.	1	
-7	102-542-ST1	.	.	.	TOOL, Piston restraining	.	.	.	1	
-8	SF-024090-021-F11	.	.	.	TOOL, Impeller housing removal	.	.	.	1	
-9	SF-024090-021-M10	.	.	.	TOOL, Impeller housing removal	.	.	.	1	
	1C2813	.	.	.	TEST STAND, Main fuel pump	.	.	.	1	
-10	SF-102-1428-G1	.	.	.	GAGE, Bore measuring	.	.	.	1	

DISASSEMBLY/ASSEMBLY FILE

NAME PHWT ALC 06 DATE 060589 RCC MATPCB SHEET 1 OF 1

TOP ASSEMBLY			INSTALLATION OPERATION NUMBER	REMOVAL OPERATION NUMBER	SUBASSEMBLY	ITEM NUMBER	CHLD WCD	CHLD WCD DATE	SAME REMOVED ITEM INSTALLED WTO ASST. YIN
ITEM NUMBER	WCD	WCD DATE							
PCN NSH PIN	38690A	CBEM07	88236	20	100	PCN NSH PIN	02-13407	CBEM07S1	
PCN NSH PIN						PCN NSH PIN	02-13390	CBEM07S	
PCN NSH PIN						PCN NSH PIN	02-13389	CBEM07S	
PCN NSH PIN						PCN NSH PIN	02-12012	CBEM07S	
PCN NSH PIN						PCN NSH PIN	02-13652	CBEM07S	
PCN NSH PIN						PCN NSH PIN	02-13619	CBEM07S	
PCN NSH PIN						PCN NSH PIN	02-13650	CBEM07S	
PCN NSH PIN						PCN NSH PIN	02-13404	CBEM07S	
PCN NSH PIN						PCN NSH PIN			
PCN NSH PIN						PCN NSH PIN			
PCN NSH PIN						PCN NSH PIN			
PCN NSH PIN						PCN NSH PIN			
PCN NSH PIN						PCN NSH PIN			

LSC-20095A

"IN" DATES PROFILE

NAME _____ ALC <u>ALC</u> DATE <u>31 MAY 89</u> RCC <u>MTPEB</u> SHEET <u>1</u> OF <u>1</u>				
PCN ISH PIN	PARENT WCD	"IN" DATE (SCHEDULED DATE)	PARENT WCD DATE	MTPEB
38670A				
1	82277		2272	21
2	82225		82225	21
3	82224		2225	24
4	90220		90220	72
5	90220		1 4	96
6	90528		90528	24
				(44)

[illegible]

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE ICC.

OPERATION PROFILE

NAME P. Hunt ALC OC DATE 6-25-89 RCC MATPCB SHEET 1 OF 3

PHI 38690A WCD C8EM08 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					%	INS.	QTY.	%	INS.	QTY.	EQUIPMENT CODE	%	INS.	
000	MATP CB	IN DATA	1.0	TRANSIT										
				SETUP										
				PROCESS		44								
010	MATP CB	TEST	1.0	TRANSIT										
				SETUP										
				PROCESS										INST. PUMP ON STAND + RUN TWO TESTS.
020	MATP CB	TEST	1.0	TRANSIT										INST. PUMP ON STAND + RUN TWO TESTS.
				SETUP										INST. PUMP ON STAND + RUN TWO TESTS.
				PROCESS										INST. PUMP ON STAND + RUN TWO TESTS.
030	MATP CB	TEST	1.0	TRANSIT										INST. PUMP ON STAND + RUN TWO TESTS.
				SETUP										INST. PUMP ON STAND + RUN TWO TESTS.
				PROCESS										INST. PUMP ON STAND + RUN TWO TESTS.
040	MATP CB	SET	1.0	TRANSIT										INST. PUMP ON STAND + RUN TWO TESTS.
				SETUP										INST. PUMP ON STAND + RUN TWO TESTS.
				PROCESS										INST. PUMP ON STAND + RUN TWO TESTS.

OPERATION PROFILE

NAME <u>P HUNT</u>		ALC <u>OC</u>		DATE <u>6-05-89</u>		RCC <u>MATPCB</u>		SHEET <u>2</u> OF <u>3</u>				
PCN <u>38690A</u>		WCD <u>CBE MO8</u>		WCD DATE <u>88236</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % INHS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % INHS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % INHS.	DATA SOURCE COMMENTS
050	MATPCB	ADJ.	1.0	TRANSIT SETUP PROCESS			1	100 .50	00912	1	100 .50	RELIEF VALVE ADJ. 00912 ACT
060	MATPCB	SET	1.0	TRANSIT SETUP PROCESS			1	100 .25	00912	1	100 .25	RELIEF VALVE CALIB. 00912 ACT
070	MATPCB	TEST	1.0	TRANSIT SETUP PROCESS			1	100 .33	00912	1	100 .33	FLOW + TORQUE TESTS. 00912 ACT
080	MATPCB	TEST	1.0	TRANSIT SETUP PROCESS			1	100 .17	00912	1	100 .17	LEAK TESTS 00912 ACT
090	MATPCB	TEST	1.0	TRANSIT SETUP PROCESS			1	100 .08	00912	1	100 .08	BREAK-AWAY TORQUE TEST 00912 ACT

OPERATION PROFILE

NAME PHUNT ALC OC DATE 6-05-89 RCC MATPCB SHEET 3 OF 3

PCN 38690A WCD CBEM08 WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT				DATA SOURCE COMMENTS																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
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100	MATP CB	OIL	1.0	TRANSIT										OIL, + Flush. CORRECT ACT TEST OPS COMPL, PW COMPL. OIL + Flush. ACT COMPLY WITH MAOI 66-36 PAR. 13 MOVE TO FINAL ASSY AREA																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
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OPERATION PROC E

NAME <u>E. Totten</u> ALC <u>OC</u> DATE <u>5/11/89</u> RCC <u>MATPCB</u> SHEET <u>1</u> OF <u>8</u>		WCD <u>CBEM10</u> WCD DATE <u>88236</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INOUTS % INRS.	MANPOWER SKILL CODE/LEVEL	QTY.	TIME REQUIRED % INRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % INRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	PROCESS	1.0 28.0							
001		REC	0.9	PROCESS			BP05 1	1.0 2.7	BEN12	1	1.0 2.7	
005		PROC	1.0	PROCESS			BP05 1	1.0 2.0	BEN12	1	1.0 2.0	
010		REC	1.0	PROCESS			AP09 1	1.0 2.0	BEN12	1	1.0 2.0	
012		PROC	1.0	PROCESS			AP09 1	1.0 2.0	BEN12	1	1.0 2.0	

OPERATION PROC. E

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 2 OF 8							
PCN _____		HSH _____		P/H _____		WCD CBFM10		WCD DATE _____							
OPERATION NO./IDEN	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INQTS		SKILL CODE/ LEVEL	MAINTPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS	
					%	INS.		QTY.	%	INS.	QTY.	%	INS.		
015	MAT PCB	CLN	1.0	PROCESS	—	—	AP09	1	1.0	0.05	OC 1178	1	1.0	0.05	
020		DIS	1.0	PROCESS	—	—		1	1.0	0.60	BEN12	1	1.0	0.60	
021		INSP	1.0	PROCESS	—	—		1	1.0	0.10	BEN12	1	1.0	0.10	
030		CLN	1.0	PROCESS	—	—		1	1.0	0.30	OC 4547	1	1.0	0.30	
031		PW	1.0	PROCESS	—	—		1	1.0	0.05	BEN12	1	1.0	0.05	

OPERATION PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET <u>3</u> OF <u>8</u>					
PCN ITEM CODE		WCD <u>CBEM10</u>		WCD DATE _____		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		QTY.	TIME REQUIRED		
								%	HRS.		%	HRS.	
032	MAT ACB	PROC	1.0	TRANSIT	—	A009	1	1.0	.20	BEN12	1	1.0	.20
				SETUP									
				PROCESS									
033		PROC	1.0	TRANSIT	—		1	1.0	.10	BEN12	1	1.0	.10
				SETUP									
				PROCESS									
035		PW	1.0	TRANSIT	—		1	1.0	.05	BEN12	1	1.0	.05
				SETUP									
				PROCESS									
036		CLN	1.0	TRANSIT	—		1	1.0	.70	BEN12	1	1.0	.70
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

NAME _____ ALC _____ DATE _____ NCC _____
SHEET 4 OF 8

SHEET 4 OF 8

ncc

DATE_

ALC

NAME _____

WCD C-BEM10

WCD DATE:

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
					%	HRS.		QTY.	TIME REQUIRED		EQUIPMENT CODE		QTY.	TIME REQUIRED	
									%	HRS.				%	HRS.
037	MAT ACM	PROC	1.0	PROCESS	1.0	1.5	AP09	1	1.0	1.0	BEN12	1	1.0	1.0	
038		PROC	1.0	PROCESS	1.0	1.5		1	1.0	1.0	BEN12	1	1.0	1.0	
045		PROC	1.0	PROCESS	1.0	1.5		1	1.0	1.0	BEN12	1	1.0	1.0	NONE
050		INSP	1.0	PROCESS	1.0	1.5		1	1.0	1.0	BEN12	1	1.0	1.0	NONE
060		INSP	1.0	PROCESS	1.0	1.5		1	1.0	1.0	BEN12	1	1.0	1.0	NONE

24.

NAME		ALC		DATE		RCC		SHEET 5 OF 8	
PCN		WCD CBE MIO		WCD DATE					
ITEM CODE		MANDATORY OCCURRENCE FACTOR		OPERATION TYPE		MANDATORY FLOW HOURS		SKILL CODE/LEVEL	
OPERATION NUMBER		OPERATION DESCRIPTION		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
RCB PIN		TIME REQUIRED %		QTY.		TIME REQUIRED %		HRS.	
061	PIAT RB	REP	1.0	PROCESS	-	APO9	1.0 .20	BEN12	1.0 .20
062		PROC	1.0	PROCESS	1.0 16.0				Backshop test facility marked (+/-)
063		ASSY	1.0	PROCESS	-	APO9	1.0 .20	BEN12	1.0 .20
064		ASSY	1.0	PROCESS	-				
065		ASSY	1.0	PROCESS	-				

Backshop
fest
facility
mailed (4.11)

OPERATION PROC. LE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 6 OF 8					
PCII _____		HSH _____		PHI _____		WCD CBE M10		WCD DATE _____					
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	%	HRS.	QTY.		%	HRS.
070	MAT PCB	PROC	1.0	TRANSFER									
				START									
				PROCESS	-	-	1	1.0	1.0	1	1.0	1.0	1.0
075		PROC	1.0	TRANSFER									
				START									
				PROCESS	-	-	1	1.0	1.0	1	1.0	1.0	1.0
080		ASSY	1.0	TRANSFER									
				START									
				PROCESS	-	-	1	1.0	1.0	1	1.0	1.0	1.0
085		ASSY	1.0	TRANSFER									
				START									
				PROCESS	-	-	1	1.0	1.0	1	1.0	1.0	1.0
090		ASSY	1.0	TRANSFER									
				START									
				PROCESS	-	-	1	1.0	1.0	1	1.0	1.0	1.0

OPERATION PRO. _E

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 7 OF 8

PCN		HSH		PIL		WCD		CBEN10		WCD DATE		DATA SOURCE COMMENTS	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED	DATA SOURCE COMMENTS	
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE			QTY.
100	MAT	ASSY	1.0	TURNOFF	—	—	—	—	—	—	—		
	SETUP			—	—	—	—	—	—	—	—		
	PROCESS			—	—	1	1.0	.42	BEN12	1	1.0		.42
110	PCB	ASSY	1.0	TURNOFF	—	—	—	—	—	—	—		
				SETUP	—	—	—	—	—	—	—		—
				PROCESS	—	—	1	1.0	.25	BEN12	1		1.0
120		ASSY	1.0	TURNOFF	—	—	—	—	—	—	—		
				SETUP	—	—	—	—	—	—	—		—
				PROCESS	—	—	1	1.0	.50	BEN12	1		1.0
130		ASSY	1.0	TURNOFF	—	—	—	—	—	—	—		
				SETUP	—	—	—	—	—	—	—		—
				PROCESS	—	—	1	1.0	.25	BEN12	1		1.0
140		ASSY	1.0	TURNOFF	—	—	—	—	—	—	—		
				SETUP	—	—	—	—	—	—	—		—
				PROCESS	—	—	1	1.0	.50	BEN12	1		1.0

OPERATION PRO. E

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 8 OF 8

WCD CBEM 10													WCD DATE			DATA SOURCE COMMENTS
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANIPULATION		EQUIPMENT		TIME REQUIRED	HRS.			
					%	HRS.		QTY.	%	HRS.	QTY.			%	HRS.	
150	MAT	TEST	1.0	PROCESS	—	—	AP09	1	1.0	.25	1	1.0	.25			
	ACB															
170		PROC	1.0	PROCESS	—	—	Ben 12	1	1.0	.05	1	1.0	.05			
185		PW	1.0	PROCESS	—	—	Ben 12	1	1.0	.16	1	1.0	.16			
9999		OUT	1.0	PROCESS	1.0	32.0	Ben 12	1	1.0	.16	1	1.0	.16			
				TRANSIT												
				SETUP												
				PROCESS												

SUBJECT 38691A FLOW PROCESS CHART DATE 6-17-89

ITEM CODE
PCN
NOM.
P/N

WCD CBEM10 WCD DATE 88236

CHART BEGINS

01 REC.

CHART ENDS

200 SHUT IT

PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
01	—	●○○□▽	REC - MSTR			○○○□▽	
05	—	●○○□▽	UNLOAD			○○○□▽	
010	010	●○○□▽	REC + DU PW			○○○□▽	
012	—	●○○□▽	PUMP TO W. IRBLENH			○○○□▽	
015	—	●○○□▽	CLEAN - PD680			○○○□▽	
020	DIS	●○○□▽	TOTALY DIS. PUMP			○○○□▽	
021	—	○○○□▽	VISUAL INSP PUMP			○○○□▽	
030	30	●○○□▽	CLEAN DIS. PUMP			○○○□▽	
040	40	○○○□▽	INSP, REPAIR PIPES			○○○□▽	
050	50	○○○□▽	NDI - GEARS/SLIPS			○○○□▽	
060	60	○○○□▽	NDI - IMPELLOR			○○○□▽	
061	—	●○○□▽	REPAIR GEARS			○○○□▽	
062	—	●○○□▽	MACHINE IMPELLOR			○○○□▽	
063	—	●○○□▽	ASSY RELIEF VALVE			○○○□▽	
064	—	●○○□▽	ASSY BEARING			○○○□▽	
065	—	●○○□▽	ASSY COVER ELEMENT			○○○□▽	
070	70	●○○□▽	LUBE ALL PARTS			○○○□▽	
075	75	●○○□▽	REAM TRACTOR PIN HOLES			○○○□▽	
080	80	●○○□▽	ASSY GEAR ELEMENT			○○○□▽	
085	85	●○○□▽	ASSY PUMP ELEMENT			○○○□▽	
090	90	●○○□▽	INSTALL TRACTOR PINS			○○○□▽	
100	100	●○○□▽	ASSY IMPELLOR HING			○○○□▽	
110	110	●○○□▽	ASSY BOOSTER ELEMENT			○○○□▽	
120	120	●○○□▽	ASSY RELIEF VALVE			○○○□▽	
130	130	●○○□▽	ASSY FILTER			○○○□▽	
140	140	●○○□▽	ASSY SEAL PAPER			○○○□▽	
150	150	○○○□▽	ROTATIONAL CHECK			○○○□▽	
160	160	○○○□▽	MUVE TO 3108			○○○□▽	
170	170	●○○□▽	SAFETY WIRE			○○○□▽	
180	180	●○○□▽	DO PAPERWORK			○○○□▽	
190	190	●○○□▽	COMPLETE TO 170			○○○□▽	
200	200	○○○□▽	MUVE TO SHUT IT			○○○□▽	

○ OPERATION

◇ TRANSPORTATION

▽ STORAGE

□ DELAY

□ INSPECTION

LSC-20147

OPERATION FILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>06/589</u>		RCC <u>OC</u>		SHEET <u>1</u> OF <u>3</u>									
PCN <u>38691A</u>		WCD <u>CBEM11</u>		WCD DATE <u>88236</u>		EQUIPMENT		DATA SOURCE COMMENTS									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			TIME REQUIRED %	TIME REQUIRED HRS.		
					%	HRS.		SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.				%
00	MATP CB	IN DATE	1.0	TRANSIT													
		SETUP															
		PROCESS															
10	MATP CB	PROC	1.0	TRANSIT													INSTALL
		SETUP															PUMP
		PROCESS															ONTO
20	MATP CB	TEST	1.02	TRANSIT													TEST STAND
		SETUP															
		PROCESS															RUN-IN
21	MATP CB	TEST	.98	TRANSIT													
		SETUP															
		PROCESS															RUN-IN
30	MATP. CB	TEST	1.0	TRANSIT													
		SETUP															RATED
		PROCESS															SPURD RUN

OPERATION PROFILE

NAME PHWT ALC OC DATE 06/5/89 RCC OC SHEET 2 OF 3

PCN 38691A WCD CB WCD DATE 88236

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.
40	MATP CB	TEST	1.0	TRANSIT									CALIBRATION		
				SETUP											
				PROCESS			DP09	1	100	.12	OC0972	1		100	.12
50	MATP CB	TEST	1.0	TRANSIT									RELIEF VALVE ADJUSTMENT		
				SETUP											
				PROCESS			DP09	1	100	.08	OC0972	1		100	.08
60	MATP CB	TEST	1.0	TRANSIT									SET/TEST RELIEF VALVE		
				SETUP											
				PROCESS			DP09	1	100	.17	OC0972	1		100	.17
70	MATP CB	TEST	1.0	TRANSIT									FLOW + TORQUE TESTS.		
				SETUP											
				PROCESS			DP09	1	100	.7	OC0972	1		100	.7
80	MATP CB	TEST	1.0	TRANSIT									LEAK TESTS		
				SETUP											
				PROCESS			DP09	1	100	.13	OC0972	1		100	.13

OPERATION PROFILE

NAME <u>PHUNT</u>		ALC <u>DC</u>		DATE <u>06/589</u>		NCC <u>OC</u>		SHEET <u>3</u> OF <u>3</u>	
PIN <u>38691A</u>		WCD <u>CBEML</u>		WCD DATE <u>88236</u>					

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.			
90	MATP CB	TEST	1.0	TRANSIT											BREAK-AWAY TURQUIS TEST
				SETUP											
				PROCESS											
100	MATP CB	PROC.	1.0	TRANSIT											OIL FLUSH
				SETUP											
				PROCESS											
110	MATP CB	PW	1.0	TRANSIT											PW COMPL.
				SETUP											
				PROCESS											
120	MATP CB	PW	1.0	TRANSIT											PW/CW
				SETUP											
				PROCESS											
9999	MATP CB	OUT DATE	1.1	TRANSIT											
				SETUP											
				PROCESS											

SUBJECT 38691A

DATE 6/5/89

WCD CBEM11 WCD DATE 88236

WCD DATE 88 236

MEM

PM

CHART BEGINS

CHART ENDS

PREPARED BY

[illegible]

○ OPERATION

▷ TRANSPORTATION

▽ STORAGE

D DELAY

☐ INSPECTION

LSC-20147

OPERATION PROFILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>61589</u>		RCC <u>CBEM12</u>		SHEET <u>1</u> OF <u>2</u>						
WCD <u>CBEM12</u>		WCD DATE <u>88236</u>		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
								%	HRS.			%	HRS.	
00	MATP CB	IN DATE	1.0	TRANSIT										
		SETUP												
		PROCESS			24									
10	MATP CB	PROC	1.0	TRANSIT										PREPARE IMPERMANENT HOUSING CHECK VARIOUS
		SETUP				AP09	1	100	.05		000972	1	100	.05
		PROCESS												
20	MATP CB	MOV	1.0	TRANSIT										ROUTE TO MTPPT/3108
		SETUP				AP09	1	100	.05					
		PROCESS												
25	MATP CB	REC	1.0	TRANSIT										RECOVER
		SETUP												
		PROCESS				DP09	1	100	.08		000972	1	100	.08
26	MATP CB	PROC	1.0	TRANSIT										ATTACH CLAMP, DISCONNECT
		SETUP				DP09	1	100	.12		000972	1	100	.12
		PROCESS												

OPERATION PROFILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>61589</u>		RCC <u>CBE M12</u>		SHEET <u>2 of 2</u>							
PCN <u>38691A</u>		WCD <u>CBE M12</u>		WCD DATE <u>88236</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.
30	MATP CB	TEST	1.0	TRANSIT											Perform LEAK TEST
				SETUP											
				PROCESS											
35	MATP CB	PROC	.3	TRANSIT											REPAIRDOWN, MISDR
				SETUP											
				PROCESS											
40	MATP CB	PW	1.0	TRANSIT											C/W IAW TO T=10
				SETUP											
				PROCESS											
50	MATP CB	PW	1.0	TRANSIT											C/W MAOI 16-36 PAR 13
				SETUP											
				PROCESS											
9999	↓	DUT	1.0	TRANSIT											
				SETUP											
				PROCESS											

SUBJECT 38691A FLOW PROCESS CHART DATE 61589

ITEM CODE
PCN
NBN.
P/N

WCD CBE M12 WCD DATE 88236

CHART BEG'NS 10 — CHk IMPULSION

CHART ENDS 50 JAPANESE PREPARED BY

[illegible]

○ OPERATION
◇ TRANSPORTATION

▽ STORAGE
D DELAY

☐ INSPECTION

LSC-20147

NAME _____		ALC <u>OC-4LC</u>		DATE <u>31 MAR 1989</u>		RCC <u>MTPCB</u>		SHEET <u>1</u> OF <u>1</u>	
PCI HSH PHI		PARENT WCD		PARENT WCD DATE		FIRST OPERATION (DATE)		Δ TIME (DAYS)	
OBSERVATION NUMBER		"1" DATE (SCHEDULED DATE)							
1		8220		8221		24			
2		8221		8222		24			
3		8222		8223		24			
4		8223		8224		24			
5		8224		8225		24			
6		8225		8226		24			
7		8226		8227		24			
8		8227		8228		24			
9		8228		8229		24			
10		8229		8230		24			
11		8230		8231		24			
12		8231		8232		24			
13		8232		8233		24			
14		8233		8234		24			
15		8234		8235		24			
16		8235		8236		24			
17		8236		8237		24			
18		8237		8238		24			
19		8238		8239		24			
20		8239		8240		24			
21		8240		8241		24			
22		8241		8242		24			
23		8242		8243		24			
24		8243		8244		24			
25		8244		8245		24			
26		8245		8246		24			
27		8246		8247		24			
28		8247		8248		24			
29		8248		8249		24			
30		8249		8250		24			
31		8250		8251		24			
32		8251		8252		24			
33		8252		8253		24			
34		8253		8254		24			
35		8254		8255		24			
36		8255		8256		24			
37		8256		8257		24			
38		8257		8258		24			
39		8258		8259		24			
40		8259		8260		24			
41		8260		8261		24			
42		8261		8262		24			
43		8262		8263		24			
44		8263		8264		24			
45		8264		8265		24			
46		8265		8266		24			
47		8266		8267		24			
48		8267		8268		24			
49		8268		8269		24			
50		8269		8270		24			
51		8270		8271		24			
52		8271		8272		24			
53		8272		8273		24			
54		8273		8274		24			
55		8274		8275		24			
56		8275		8276		24			
57		8276		8277		24			
58		8277		8278		24			
59		8278		8279		24			
60		8279		8280		24			
61		8280		8281		24			

~~SECRET~~

NOTE: THIS DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD ON DATE

30

"OUT" DATES PROC. LE

NAME _____		ALC <u>GC-ALC</u>	DATE <u>31 MAY 89</u>	RCC <u>MT PCB</u>	SHEET <u>1</u> OF <u>1</u>
PCI	PIH	PIH	PARENT WCD	PARENT WCD DATE	
49802A					
OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	TIME		
1	8295	8298	72		
2	8309	8309	00		
3	8336	8337	24		
4	8354	8357	72		
5	8358	8358	0		
6	9017	9018	24		
7	9030	9030	0		
8	9034	9037	72		
9	9052	9052	0		
10	9067	9069	113		
			32		

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATION PROFILE

NAME <u>E. TOTEN</u> ALC <u>OC</u> DATE <u>5/9/82</u> RCC <u>MAT PCB</u> SHEET <u>1</u> OF <u>4</u>		WCD <u>CBEA T1A</u> WCD DATE <u>88124</u>		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	TIME REQUIRED		QTY.	EQUIPMENT CODE	TIME REQUIRED		QTY.	EQUIPMENT	DATA SOURCE COMMENTS	
					%	HRS.		%	HRS.			%	HRS.				
00	MAT PCB	IN	1.0	TRANSIT	1.0	36.0											
010		REC	1.0	PROCESS													
020		PROC	.33	PROCESS													
030		PROC	1.0	PROCESS													
040		PROC	1.0	PROCESS													

OPERATION PR FILE

NAME _____ ALC _____ DATE _____		RCC _____		SHEET <u>2</u> OF <u>4</u>							
WCD <u>CBAT 2A</u>		WCD DATE <u>8/17/74</u>									
WCD <u>49802A</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	MANPOWER	TIME REQUIRED	EQUIPMENT	TIME REQUIRED	DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	QTY.	%	HRS.
050	MAT PCB	PROC	1.0	PROCESS	-	-	1	1.0	OC 1132	1.0	1.0
060		PROC	1.0	PROCESS	-	-	1	1.0	OC 1132	1.0	1.0
070		TEST	1.0	PROCESS	-	-	1	1.0	OC 1132	1.0	1.0
080		TEST	1.0	PROCESS	-	-	1	1.0	OC 1132	1.0	1.0
090		TEST	1.0	PROCESS	-	-	1	1.0	OC 1132	1.0	1.0

OPERATION PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 3 OF 4							
PCN _____		WCD 45802A		WCD CBEAT 1 A		WCD DATE _____									
PHI _____															
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS				
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE		QTY.	%	HRS.	
100	MAT	PROC	1.0	PROCESS	-	-	1	1.0	1.0	OC 1132	1	1.0	1.0	0.2	
110	PCB	PROC	.80	PROCESS	-	-	1	1.0	4.0	OC 1132	1	1.0	4.0		
120		REP	.80	PROCESS	-	-	1	1.0	.05	OC 1132	1	1.0	.05		
130		CLN	1.0	PROCESS	-	-	1	1.0	.80	OC 1132	1	1.0	.80		
140		PROC	1.0	PROCESS	-	-	1	1.0	.01	OC 1132	1	1.0	.01		

[illegible]

OPERATION PROFILE

NAME E. Totten ALC OL DATE 04/20/89 RCC MATPCB SHEET 1 OF 5

PCN 49806A WCD CBE401B WCD DATE 89088

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.			%	HRS.			%	HRS.	
00	MAT PCB	IN	1.0	TURNUP											
				SETUP											
				PROCESS	1.0	36.0									
020		REC	1.0	TURNUP											
				SETUP											
				PROCESS	-	-	BP09	1	1.0	4.5	BEN40	1	1.0	4.5	
075		OIS	1.0	TURNUP											
				SETUP											
				PROCESS	-	-		1	1.0	4.5	BEN40	1	1.0	4.5	
115		INSP	1.0	TURNUP											
				SETUP											
				PROCESS	-	-		1	1.0	1.0	BEN40	1	1.0	1.0	
135		PROC	1.0	TURNUP											
				SETUP											
				PROCESS	-	-		1	1.0	1.2	BEN40	1	1.0	1.2	

OPERATIC PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 5

PCN _____ NSN _____ PIN _____ WCD CBE 4018 WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	%	HRS.	
150	MAT	CLN	1.0	PROCESS	-	-	BP09	1	1.0	1.0	1.0	1.0	total of of 3.0 hrs cln.
	PCEB			PROCESS	-	-		1	1.0	1.0	1.0	1.0	
				PROCESS	-	-		1	1.0	1.0	1.0	1.0	
160		PROC	1.0	PROCESS	1.0	8.0		1	1.0	1.0	1.0	1.0	dry
				PROCESS	-	-							
				PROCESS	-	-							
180	MAT	MACH	1.0	PROCESS	-	-							
	CM			PROCESS	-	-							
				PROCESS	-	-							
190	MAT	INSP	1.0	PROCESS	-	-	BP09	1	1.0	1.0	1.0	1.0	
	PCEB			PROCESS	-	-							
				PROCESS	-	-							
200		REP	1.0	PROCESS	-	-		1	1.0	1.0	1.0	1.0	
				PROCESS	-	-							
				PROCESS	-	-							

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 of 5

PCN _____ NSN _____ P/N _____ WCD CBE4010 VICD DATE _____

P/N	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
						%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.
215	MAT PCB		INSP	1.0	TRANSFER											
					SETUP											
					PROCESS	-	-	BPO9	1	1.0	0.02	BEN40	1	1.0	0.02	
235		PROC	1.0	TRANSFER												
				SETUP												
				PROCESS	-	-		1	1.0	1.12	BEN40	1	1.0	1.12		
250		REP	1.0	TRANSFER												
				SETUP												
				PROCESS	-	-		1	1.0	1.10	BEN40	1	1.0	1.10		
265	MAT PCM		MACH	1.0	TRANSFER											
					SETUP											
					PROCESS	1.0	24.0									
280	MAT PCB		PROC	1.0	TRANSFER											
					SETUP											
					PROCESS	-	-	BPO9	1	1.0	2.5	BEN40	1	1.0	2.5	

OPERATIONAL PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 4 OF 5

WCD CBE 4013

WCD DATE _____

PCH
NSN
P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MAINPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	QTY.	%	HRS.	
290	MAT RCS	CLN	1.0	TRANSFER	—	—	BP09	1	1.0	1.0	1	1.0	1.0	
				SETUP	—	—								
				PROCESS	—	—				OC 1178	1	1.0	1.0	
300		INSP	1.0	TRANSFER	—	—								
				SETUP	—	—								
				PROCESS	—	—		1	1.0	1.0	BEN40	1	1.0	1.0
310		ASSY	1.0	TRANSFER	—	—								
				SETUP	—	—								
				PROCESS	—	—		1	1.0	1.0	BEN40	1	1.0	1.0
335		PRAC	1.0	TRANSFER	—	—								
				SETUP	—	—								
				PROCESS	—	—		1	1.0	1.5	BEN40	1	1.0	1.5
360		DTS	1.0	TRANSFER	—	—								
				SETUP	—	—								
				PROCESS	—	—		1	1.0	1.05	BEN40	1	1.0	1.05

OPERATING PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ WCD _____ VCD DATE _____

PCN _____ NSN _____ P/N _____

WCD 4018 VCD 4018 SHEET 5 OF 5

PIN		OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS				
							%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.			
370	MAT ACB	INSP	1.0	TRANSFER	—	—	—	BPO9	1	1.0	.02	OC Q229	1	1.0	.02	NONE			
																	SETUP	—	—
																	PROCESS	—	—
390		INSP	1.0	TRANSFER	—	—	—		1	1.0	.01	BEN40	1	1.0	.01				
																	SETUP	—	—
																	PROCESS	—	—
415		PROC	1.0	TRANSFER	—	—	—		1	1.0	.15	BEN40	1	1.0	.15				
																	SETUP	—	—
																	PROCESS	—	—
444		PW	1.0	TRANSFER	—	—	—		1	1.0	.26	BEN40	1	1.0	.26				
																	SETUP	—	—
																	PROCESS	—	—
9999		OUT	1.0	TRANSFER	—	—	—		1	1.0	.32								
																	SETUP	—	—
																	PROCESS	—	—

5, 6, 7, 8A

SUBJECT J57 MANIFOLDS FLOW PROCESS CHART DATE 4/21/89

ITEM CODE
PCN ☒
NOM ☐
PM ☐
WCD CBE401 WCD DATE 89088
4522A, 4980GA, 4980BA, 4980CA MAT PCB

CHART BEGINS _____ PREPARED BY E. TOTTER
CHART ENDS _____

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●○○□▽	RECEIVE MANIFOLDS IN BLDG 3123		340	●○○□▽	CAP NOZZLES AND INLET FLANGE
011		●○○□▽	LINE RATE MANIFOLDS (NOOP PERSONNEL)		350	○●○○□▽	MOVE TO TEST IN BLDG 3108
012		○●○○□▽	MOVE MANIFOLDS TO BLDG 3001 O/H SHED		350	○●○○□▽	DELAY FOR TESTING IAW CBT401
013		●○○□▽	UNLOAD, STORE ON SHED FLOOR		350	○●○○□▽	RETURN FROM TEST TO BLDG 3001 O/H
014		●○○□▽	REMOVE MANIFOLD FROM SHIPPING CARDS			●○○□▽	DEMOUNT MANIFOLD FROM METAL SHIP EXT.
015		●○○□▽	REMOVE NOZZLE DUST CAPS, OIL NOZZLES		360	○●○○□▽	DISTORTION/NOOP CHECK INSPECT FLANGE, ETC.
016		○●○○□▽	WAIT 1-1 1/2 HRS FOR OIL TO LOOSEN NOZZLES		360	●○○□▽	COLD BEND MANIFOLD IF WARPED
020	020	●○○□▽	REMOVE NOZZLE (24) FM MANIFOLD, CLOS.		365	○●○○□▽	VISUALLY INSPECT NOOP SHIELDS / WELDS FOR CRACKS
021		●○○□▽	REMOVE TABLOCKS AND GASKETS FROM NOZZLES		368	●○○□▽	SEND TO WELDING FOR CRACK REPAIR, IF KEV
022		●○○□▽	SEPARATE NOZZLES; PLACE IN SHIP TRAYS			○●○○□▽	
030		○●○○□▽	VISUALLY INSPECT MANIFOLD & IDENTIFY		370	●○○□▽	CAN PORTS, SECURE ELBOWS TO FLANGE ETC.
050	050	●○○□▽	MEASURE INLET FLANGE THICKNESS DIMENSION			●○○□▽	POUNT MANIFOLD IN WOOD SHIPPING SHED
065	065	●○○□▽	DRILL 4 #55 HOLES IN CLUSTER DUMMY TUBES		380	●○○□▽	COMPLETE WELDING PREPARE PARTS 349
070		●○○□▽	INSTALL RESTRICTIONS IN HEAD, NOZZLE PORTS		390	●○○□▽	TAG MANIFOLD STRAIN PAPER/SHIELD
080		●○○□▽	CLEAN MANIFOLD IAW T.O.		400	●○○□▽	COMPLETE WELDING Q 13 L'ELL
090		●○○□▽	REMOVE RESTRICTIONS NOZZLES/HEAD, IT/THAK			○●○○□▽	
100		○●○○□▽	HANG IN RACK TO DRY - MIN 8 HRS			○●○○□▽	
150		●○○□▽	TRANSFER TO/FROM MACHINE SHOP			○●○○□▽	
220	220	○●○○□▽	PERFORM MANIFOLD OPERATION/WARP/HEAT			○●○○□▽	
221	220	●○○□▽	COLD BEND MANIFOLD IN WAREHOUSE			○●○○□▽	
222		○●○○□▽	INSPECT HEATSHIELD WELDS FOR CRACKS			○●○○□▽	
	221	○●○○□▽	INSPECT FOR NOZZLE CLUSTER DISTORTION			○●○○□▽	
		●○○□▽	ALIGN MANIFOLD HEADS			○●○○□▽	
	223	●○○□▽	IF PERFORM MANI- FOLD TORQUE BOLT LOCATION			○●○○□▽	
	223	●○○□▽	REPLACE LOOSE/DAMAGED COMBUSTION CHAMBER			○●○○□▽	
250		●○○□▽	DEMOUNT MANIFOLD ON METAL SHIP EXT.; INSTA			○●○○□▽	
260		●○○□▽	BACKSIFT MAKING AND WELDING SHIPS			○●○○□▽	
290	290	●○○□▽	INSPECT NOZZLE BODY, SEAL THROAT, LAP S			○●○○□▽	
300	300	●○○□▽	FLUSH MANIFOLD W/ PU-GRO			○●○○□▽	
	290	○●○○□▽	MEASURE NOZZLE SEAT DEPTH DIMENSION			○●○○□▽	
	310*	●○○□▽	SELECT, INSTALL CORAL NOZZLES, SEAT, THROAT			○●○○□▽	
	330	○●○○□▽	IDENTIFY & DOCUMENT I/N S/N OF MANIFOLD			○●○○□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
◐ TRANSPORTATION D DELAY

* INCLUDES WCD OPERATION 320
NOTE: TRANSIT TIMES BETWEEN MOST OPERATIONS ARE LESS THAN 6 MINUTES AND ARE
INCLUDED IN OPERATIONS

FILE

SHEET 1 OF 1

ASSEMBLY

LSC-2(X)SA

WE WILL BE INTERCHANGEABLE IN ALL 4 DIRECTIONS

OPERATION PROFILE

NAME <u>E. TOTEN</u>		ALC <u>OC</u>		DATE <u>5/19/87</u>		RCC <u>MATPCB</u>		SHEET <u>1</u> OF <u>4</u>				
PCN <u>49806A</u>		WCD <u>CBAH118</u>		WCD DATE <u>88124</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INOURS		MANPOWER		EQUIPMENT		TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE		
00	MAT PCB	IN	1.0	TRANSIT								
				SETUP								
				PROCESS								
010		REC	1.0	TRANSIT								
				SETUP								
				PROCESS								
020		PROC	.33	TRANSIT								
				SETUP								
				PROCESS								
030		PROC	1.0	TRANSIT								
				SETUP								
				PROCESS								
040		PROC	1.0	TRANSIT								
				SETUP								
				PROCESS								

OPERATION PR FILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 3 OF 4						
WCD 49806A		WCD CBEAT 1B		WCD DATE 85174										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INQUIRY	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCB	PROC	1.0	TRANSIT	-	QC 09	1	1.0	20	1132	1	1.0	20	
060		PROC	1.0	TRANSIT	-		1	1.0	20	1132	1	1.0	20	
070		TEST	1.0	TRANSIT	-		1	1.0	20	1132	1	1.0	20	
080		TEST	1.0	TRANSIT	-		1	1.0	20	1132	1	1.0	20	
090		TEST	1.0	TRANSIT	-		1	1.0	20	1132	1	1.0	20	

OPERATION PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 3 OF 4							
PCN HSH PH		WCD 49806A		WCD CBEAT 18		WCD DATE									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS				
					%	INS.	QTY.	%	INS.	EQUIPMENT CODE		QTY.	%	INS.	
100	MAT PCB	PROC	1.0	PROCESS	-	-	DP29	1	1.0	1.0	OC 1132	1	1.0	1.0	
110		PROC	.80	PROCESS	-	-		1	1.0	4.0	OC 1132	1	1.0	4.0	
120		REP	.80	PROCESS	-	-		1	1.0	.05	OC 1132	1	1.0	.05	
130		CLN	1.0	PROCESS	-	-		1	1.0	.80	OC 1132	1	1.0	.80	
140		PROC	1.0	PROCESS	-	-		1	1.0	.01	OC 1132	1	1.0	.01	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 4 OF 4

PCN 49806A WCD CBEAT 1 B WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	EQUIPMENT CODE	QTY.	
150	MAT	PROC	1.0	PROCESS	—	—	DP09	1	1.0	BEN	1	1.0 .05
160		PW	1.0	PROCESS	—	—		1	1.0	BEN	1	1.0 .05
170		PW	1.0	PROCESS	—	—		1	1.0	BEN	1	1.0 .20
9999		OUT	1.0	PROCESS	1.0	32.0						
				TRANSIT								
				SETUP								
				PROCESS								

"IN" DATES PROFILE

NAME _____ ALC <u>OC-ALC</u> DATE <u>31 MAY 89</u> RCC <u>MPCCB</u> SHEET <u>1</u> OF <u>1</u>			
PCI <u>49806A</u> PATIENT WCD _____ PATIENT WCD DATE _____			
OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	HRS Δ TIME (HRS)
1	8264	8264	0
2	8293	8295	48
3	8298	8299	24
4	8306	8306	0
5	8306	8307	24
6	8323	8323	0
7	9017	9018	24
8	9017	9018	24
9	9030	9032	08
10	9041	9044	72
			(27)

"OUT" DATES PROC. LE

NAME _____ ALC <u>OC-ALC</u> DATE <u>31 MAY 89</u> PCC <u>MT PCB</u> SHEET <u>1</u> OF <u>1</u>		PARENT WCD DATE _____		PARENT WCD DATE _____		
PCN	ISSN	PHN	49806A	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	A TIME (DAYS)
1			8281	8281	0	
2			8213	8214	24	
3			8319	8319	0	
4			8323	8326	72	
5			8326	8326	0	
6			8347	8348	24	
7			9037	9037	0	
8			9037	9038	24	
9			9047	9048	24	
10			9060	9061	24	
					(20)	

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATIONAL PROFILE

NAME <u>E. Totten</u>		ALC <u>0C</u>		DATE <u>04/20/89</u>		RCC <u>MAT PCB</u>		SHEET <u>1</u> OF <u>5</u>		
PCN <u>49808A</u>		WCD <u>CBE401C</u>		WCD DATE <u>89088</u>						
PIN		MANDATORY FLOW THOURS		MAIN POWER		EQUIPMENT		DATA SOURCE COMMENTS		
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.
00	MAT PCB	IN	1.0	TURNUP						
				SETUP						
				PROCESS	1.0	36.0				
020		REC	1.0	TURNUP						
				SETUP						
				PROCESS			BP09	1	1.0	4.5
075		OIS	1.0	TURNUP						
				SETUP						
				PROCESS				1	1.0	4.5
115		INSP	1.0	TURNUP						
				SETUP						
				PROCESS				1	1.0	1.0
135		PROC	1.0	TURNUP						
				SETUP						
				PROCESS				1	1.0	1.2

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ WCD DATE _____ SHEET 2 OF 5

PCN NSN PIN			WCD CBE401C		WCD DATE		WCD								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MAINPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.		QTY.	%	HRS.	QTY.	%	HRS.		
150	MAT	CLN	1.0	PROCESS	-	-	BP09	1	1.0	OC	1	1.0	1.0	Total of of 3.0 hrs c/n.	
	PEB			PROCESS	-	-		1	1.0	OC	1	1.0	1.0		
				PROCESS	-	-		1	1.0	OC	1	1.0	1.0		
160		PROC	1.0	TRANSIT										dry	
				SETUP											
				PROCESS	1.0	8.0		1	1.0	BEN40	1	1.0	1.0		
180	MAT	MACH	1.0	TRANSIT											
	CM			SETUP											
				PROCESS	1.0	72.0									
190	MAT	INSP	1.0	TRANSIT			BP09	1	1.0	BEN40	1	1.0	1.0		
	PEB			SETUP											
				PROCESS	-	-									
200		REP	1.0	TRANSIT											
				SETUP											
				PROCESS	-	-		1	1.0	BEN40	1	1.0	1.0		

OPERATIC PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 5

PCN NSN PIN	WCD	CBE401C	DATE	RCC	WCD DATE	MANPOWER			EQUIPMENT			TIME REQUIRED HRS.	DATA SOURCE COMMENTS							
						SKILL CODE/ LEVEL	QTY.	%	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.			%						
215	MAT PCB	INSP	1.0			PROCESS	BPO9	1	1.0	.02	BEN40	1	1.0	.02						
235		PROC	1.0			PROCESS		1	1.0	.12	BEN40	1	1.0	.12						
250		REP	1.0			PROCESS		1	1.0	.10	BEN40	1	1.0	.10						
265	MAT PCN	MACH	1.0			PROCESS														
280	MAT PCB	PROC	1.0			PROCESS	BPO9	1	1.0	2.5	BEN40	1	1.0	2.5						

OPERATIONAL PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 9 OF 5				
PCN _____		NSN _____		WCD CBE 401C		WCD DATE _____						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE		
290	MAT ACB	CLN	1.0	TRANSFER SETUP PROCESS	—	—	1	1.0	1	1.0	1.0	
300		INSP	1.0	TRANSFER SETUP PROCESS	—	—	1	1.0	1	1.0	1.0	
310		ASSY	1.0	TRANSFER SETUP PROCESS	—	—	1	1.0	1	1.0	1.0	
335		PRAC	1.0	TRANSFER SETUP PROCESS	—	—	1	1.0	1	1.0	1.0	
360		DIS	1.0	TRANSFER SETUP PROCESS	—	—	1	1.0	1	1.0	1.0	

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 5 OF 5

PCN NSN PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MAINPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS	
						%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.			
370	MAT ACB		INSP	1.0	TRANSPORT													NOTE
			SETUP															
			PROCESS															
390			INSP	1.0	TRANSPORT													
			SETUP															
			PROCESS															
415			PROC	1.0	TRANSPORT													
			SETUP															
			PROCESS															
444			PW	1.0	TRANSPORT													
			SETUP															
			PROCESS															
4599			OUT	1.0	TRANSPORT													
			SETUP															
			PROCESS															

5,6,7,8A

SUBJECT J57 MANIFOLDS FLOW PROCESS CHART

DATE 4/21/89

ITEM CODE
PCN ☒
NBN ☐
PIN ☐

WCD CBE401 WCD DATE 89088

4982A, 4985A, 4988A, 4989A

MAT PCB

CHART BEGINS

CHART ENDS

PREPARED BY E. TOTTER

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●○○○▽	RECEIVE MANIFOLDS IN BLDG 3123		340	●○○○▽	CAP NOZZLES AND INLET FLANGE
011		●○○○▽	LINCINATE MANIFOLDS (SHIP PERSONNEL)		350	○○○○▽	MOVE TO TEST IN BLDG 3108
012		○○○○▽	MOVE MANIFOLDS TO BLDG 3001 O/H SHOP		350	○○○○▽	DELAY FOR TESTING IAW CBT401
013		●○○○▽	UNLOAD; STORE ON SHOP FLOOR		350	○○○○▽	RETURN FROM TEST TO BLDG 3001 O/H
014		●○○○▽	REMOVE MANIFOLD FROM SHIPPING BOARDS			●○○○▽	DEMOUNT MANIFOLD FROM METAL SHIP PTR
015		●○○○▽	REMOVE NOZZLE DUST CAPS; OIL NOZZLES		360	○○○○▽	DISTORTION/WARP CHECK INSPECT FLANGE, ETC.
016		○○○○▽	WAIT 1-1 1/2 HRS FOR OIL TO LOOSEN NOZZLES		360	●○○○▽	COLD BEND MANIFOLD IF WARPED
020	020	●○○○▽	REMOVE NOZZLES (24) FM MANIFOLD; CLOS.		365	○○○○▽	VISUALLY INSPECT HEAT SHIELDS / WELDS FOR CRACKS
021		●○○○▽	REMOVE TABLOCKS AND SEALS FROM NOZZLES		368	●○○○▽	SEND TO WELDING FOR CRACK REPAIR IF NEEDED
022		●○○○▽	SEPARATE NOZZLES; PLACE IN SHIP TRAYS			○○○○▽	
030		○○○○▽	VISUALLY INSPECT MANIFOLD & IDENTIFY		370	●○○○▽	CAP PORTS; SECURE BOLTS TO FRAME ETC.
050	050	●○○○▽	MEASURE INLET FLANGE THICKNESS DIMENSION			●○○○▽	MOUNT MANIFOLD ON WOOD SHIPPING BOARD
065	065	●○○○▽	DRILL 4 #55 HOLES IN CLUSTER DUMMY TUBES		380	●○○○▽	COMPLETE & PROCESS INFLUENCE ACTS 249
070		●○○○▽	INSTALL RESTRAINTS IN HEAD; NOZZLE PORTS		390	●○○○▽	TAG MANIFOLD ATTACH PAPERWORK
080		●○○○▽	CLEAN MANIFOLD IAW T.O.		400	●○○○▽	CHECK W/ MAJOR CG-25 Q 13 CELL
090		●○○○▽	REMOVE RESTRAINTS FROM NOZZLES / HEADS; 1 1/2 HRS			○○○○▽	
100		○○○○▽	HANG IN RACK TO DRY - MIN 8 HRS			○○○○▽	
150		●○○○▽	TRANSFER TO / FROM MACHINE SHOP			○○○○▽	
220	220	○○○○▽	PERFORM MANIFOLD DISTORTION/WARP CHECK			○○○○▽	
221	220	●○○○▽	COLD BEND MANIFOLD IF WARPED			○○○○▽	
222		○○○○▽	INSPECT HEATSHIELDS & WELDS FOR CRACKS			○○○○▽	
	221	○○○○▽	INSPECT FOR NOZZLE CLUSTER DISTORTION			○○○○▽	
		●○○○▽	ALIGN MANIFOLD HEADS			○○○○▽	
	223	●○○○▽	IF FLEET MOUNT MANI: STD TORQUE BOLTS; LOCATE			○○○○▽	
	223	●○○○▽	REPLACE LOOSE / DAMAGED COMBUSTION CHAMBER E			○○○○▽	
250		●○○○▽	REMOUNT MANIFOLD ON METAL SHIP PTR; INSTA			○○○○▽	
260		●○○○▽	BACKSIFT; MAKEWELD AND WELDING SHOPS			○○○○▽	
290	290	●○○○▽	INSPECT NOZZLE BODY GASKET THREADS; CAP'S			○○○○▽	
300	300	●○○○▽	FLUSH MANIFOLD W/ PU-G90			○○○○▽	
	290	○○○○▽	MEASURE NOZZLE GGT DEPTH DIMENSION			○○○○▽	
	310*	●○○○▽	SELECT & INSTALL CORAL NOZZLES; LEAK; TIGHTEN			○○○○▽	
	330	○○○○▽	IDENTIFY & DEMOUNT VIN / SN OF MANIFOLD			○○○○▽	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

□ DELAY

* INCLUDES WCO OPERATION 320

NOTE: TRANSIT TIMES BETWEEN MOST OPERATIONS ARE LESS THAN 6 MINUTES AND ARE
INCLUDED IN A SEPARATE

LSC-20147

7011E

NAME E. TOTTEN ALC OC DATE 5-1-89 RCC MAT-PUB SHEET 1 OF 1

[illegible]

NOTE: ① NOZZLES REMOVED ARE NOT MATCHED SETS AND ARE NOT REQUIRED TO BE REINSTALLED
IN SAME MANIFOLD FROM WHICH REMOVED.
② NOZZLES ARE INTERCHANGEABLE IN ALL 4 MANIFOLD SECTIONS

OPERATION PROC. ILE

NAME <u>E. TOTEN</u> ALC <u>OC</u> DATE <u>5/9/87</u> RCC <u>MATPCB</u> SHEET <u>1</u> OF <u>4</u>		WCD <u>CBAH T L C</u> WCD DATE <u>88124</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	
00	MAT PCB	IN	1.0	TRANSIT	1.0	36.0					
010		REC	1.0	PROCESS							
020		PROC	.33	PROCESS							
030		PROC	1.0	PROCESS							
040		PROC	1.0	PROCESS							

OPERATION PR. ILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 2 OF 4						
WCD 45808A		WCD CBEAT 1 C		WCD DATE 88174										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAINPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
					%	HRS.	QTY.	SKILL CODE/ LEVEL	%	HRS.				QTY.
050	MAT PCB	PROC	1.0	PROCESS	-	-	1	QPO9	1.0	.20	1	1.0	.20	
060		PROC	1.0	PROCESS	-	-	1		1.0	.20	1	1.0	.20	
070		TEST	1.0	PROCESS	-	-	1		1.0	.20	1	1.0	.20	
080		TEST	1.0	PROCESS	-	-	1		1.0	.20	1	1.0	.20	
090		TEST	1.0	PROCESS	-	-	1		1.0	.20	1	1.0	.20	

OPERATION PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 3 OF 4					
PCN _____		RSH _____		PRN _____		WCD 49808A		WCD CBETLC		WCD DATE _____			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
					%	HRS.		QTY.	%	HRS.	QTY.		%
100	MAT	PROC	1.0	PROCESS	-	-	DP09	1	1.0	02	1	1.0	02
110	PCB	PROC	.80	PROCESS	-	-		1	1.0	4.0	1	1.0	4.0
120	REP	REP	.80	PROCESS	-	-		1	1.0	05	1	1.0	05
130	CLN	CLN	1.0	PROCESS	-	-		1	1.0	80	1	1.0	80
140	PROC	PROC	1.0	PROCESS	-	-		1	1.0	01	1	1.0	01

OPERATION PROC FILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 4 OF 4

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	QTY.	%		
150	MAT	PROC	1.0	PROCESS	1.0	1.0	DPO9	1	1.0	1.0	1.0	1.0	
160		PW	1.0	PROCESS	1.0	1.0		1	1.0	1.0	1.0	1.0	
170		PW	1.0	PROCESS	1.0	1.0		1	1.0	1.0	1.0	1.0	
9999		OUT	1.0	PROCESS	1.0	32.0		1	1.0	1.0	1.0	1.0	
				TRANSIT									
				SETUP									
				PROCESS									

"IN" DATES PROFILE

NAME _____		ALC <u>OC-ALC</u>		DATE <u>31 MAY 87</u>		RCC <u>MTFCB</u>		SHEET <u>1</u> OF <u>1</u>	
PCN _____		PATIENT WCD _____		PATIENT WCD DATE _____					
PIN <u>49808A</u>									
OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DAYS)						
1	8264	8265	24						
2	8278	8279	24						
3	8294	8298	96						
4	8298	8299	24						
5	8298 9005	9005	0						
6	9018	9019	24						
7	9031	9031	0						
8	9031	9031	0						
9	9038	9040	48						
10	9038	9039	24						
			<u>27</u>						

"OUT" DATES PROGRAM

NAME _____		ALC <u>OC-ALC</u>		DATE <u>31 MAY 89</u>	RCC <u>MTPCB</u>	SHEET <u>1</u> OF <u>1</u>
PCI	PARENT WCD DATE					
49808A						
PHI	PARENT WCD		LAST OPERATION (COMPLETION DATE)		"OUT" DATE (SCHEDULING SELL DATE)	HRS & TIME (MMSS)
1	8281		8281		8281	0
2	8293		8293		8295	48
3	8309		8309		8309	0
4	8312		8312		8314	48
5	9025		9025		9026	24
6	9038		9038		9038	0
7	9047		9047		9048	24
8	9048		9048		9048	0
9	9060		9060		9061	24
10	9060		9060		9060	0
						(17)

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATION PROFILE

NAME <u>E. Tohen</u> ALC <u>OL</u> DATE <u>04/20/89</u> RCC <u>MATPCB</u> SHEET <u>1</u> OF <u>5</u>		WCD <u>498104</u> WCD DATE <u>89088</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	TRANSIT	1.0 36.0							
020		REC	1.0	PROCESS								
075		OIS	1.0	PROCESS								
115		INSP	1.0	PROCESS								
135		PROC	1.0	PROCESS								

OPERATIC PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 2 OF 5						
PCH NSN P/N		WCD CBE4010		WCD DATE _____		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS				
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INOURS		QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.		%	HRS.			%	HRS.	
150	MAT	CLN	1.0	PROCESS	-	-	1	1.0	1.0	OC	1	1.0	1.0	Total of of 3.0 hrs c/n.
	P/B			PROCESS	-	-	1	1.0	1.0	OC	1	1.0	1.0	
				PROCESS	-	-	1	1.0	1.0	OC	1	1.0	1.0	
160	}	PROC	1.0	TRANSIT	-	-							dry	
				SETUP	-	-								
				PROCESS	1.0	8.0	1	1.0	1.0	BEN40	1	1.0		1.0
180	MAT	MACH	1.0	TRANSIT	-	-								
	CM			SETUP	-	-								
				PROCESS	1.0	72.0								
190	MAT	INSP	1.0	TRANSIT	-	-								
	P/B			SETUP	-	-								
				PROCESS	-	-	1	1.0	1.0	BEN40	1	1.0		1.0
200	}	REP	1.0	TRANSIT	-	-								
					SETUP	-	-							
					PROCESS	-	-	1	1.0	1.0	BEN40	1		1.0

OPERATING PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 5

WCD CBE401D

WCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INOURS		SKILL CODE/ LEVEL	MAINPOWER		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	%			%	HRS.	
215	MAT PCB	INSP	1.0	TRANSFER												
				SETUP												
				PROCESS	-	-	BPO9	1	1.0	1.0		GEN40	1	1.0	1.0	
235		PROC	1.0	TRANSFER												
				SETUP												
				PROCESS	-	-		1	1.0	1.2		GEN40	1	1.0	1.2	
250		REP	1.0	TRANSFER												
				SETUP												
				PROCESS	-	-		1	1.0	1.0		GEN40	1	1.0	1.0	
265	MAT PCN	MACH	1.0	TRANSFER												
				SETUP												
				PROCESS	1.0	24.0										
280	MAT PCB	PROC	1.0	TRANSFER												
				SETUP												
				PROCESS	-	-	BPO9	1	1.0	2.5		GEN40	1	1.0	2.5	

OPERATIONAL PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 4 OF 5						
PCH NSN P/N		WCD CBE 401D		VICD DATE _____		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS				
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%	HRS.			%	HRS.			%	HRS.
290	MAT RCS	CLN	1.0	PROCESS	—	—	BPO9	1	1.0	1.0	OC 1178	1	1.0	1.0
300		INSP	1.0	PROCESS	—	—		1	1.0	1.0	BEN40	1	1.0	1.0
310		ASSY	1.0	PROCESS	—	—		1	1.0	1.0	BEN40	1	1.0	1.0
335		PRAC	1.0	PROCESS	—	—		1	1.0	1.5	BEN40	1	1.0	1.5
360		DIS	1.0	PROCESS	—	—		1	1.0	1.05	BEN40	1	1.0	1.05

OPERATION PROFILE

NAME _____ ALC _____ DATE _____		RCC _____		SHEET 5 OF 5			
PCN _____		WCD < BE 4010		VCD DATE _____			
PIN _____		MANDATORY OCCURRENCE FACTOR		OPERATION DESCRIPTION			
OPERATION NUMBER		RCC		OPERATION TYPE			
		MANDATORY FLOW HOURS		TIME REQUIRED			
		%		HRS.			
		HRS.		HRS.			
		QTY.		EQUIPMENT			
		SKILL CODE/LEVEL		EQUIPMENT CODE			
		QTY.		QTY.			
		TIME REQUIRED		TIME REQUIRED			
		%		%			
		HRS.		HRS.			
		HRS.		HRS.			
		DATA SOURCE		COMMENTS			
370	MAT PCB	1.0	INS	PROCESS	1.0 .02	1.0 .02	NOZ
390	INS	1.0	INS	PROCESS	1.0 .01	1.0 .01	
415	PROC	1.0	INS	PROCESS	1.0 .15	1.0 .15	
444	PW	1.0	INS	PROCESS	1.0 .26	1.0 .26	
4999	OUT	1.0	INS	PROCESS	1.0 .32	1.0 .32	

5, 6, 7, 8A

SUBJECT J57 MANIFOLDS FLOW PROCESS CHART

DATE 4/21/89

ITEM CODE
PCN
NOM
PIN

WCD CBE401 WCD DATE 89088

4462A, 4486A, 4488A, 49810A

MAT PCB

CHART BEGINS

CHART ENDS

PREPARED BY E. TOTTER

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●○○□▽	RECEIVE MANIFOLDS IN BLDG 3123		340	●○○□▽	CAP NOZZLES AND INLET FLANGE
011		●○○□▽	UNCRATE MANIFOLDS (SHOP PERSONNEL)		350	○○○□▽	MOVE TO TEST IN BLDG 3108
012		○○○□▽	MOVE MANIFOLDS TO BLDG 3001 G/H SHED		350	○○○□▽	DELAY FOR TESTING IAW CBT401
013		●○○□▽	UNLOAD: STORE ON SHOP FLOOR		350	○○○□▽	RETURN FROM TEST TO BLDG 3001 G/H
014		●○○□▽	REMOVE MANIFOLDS FROM SHIPPING COARDS			●○○□▽	DEMOUNT MANIFOLD FROM METAL SHIP FTR.
015		●○○□▽	REMOVE NOZZLE DUST CAPS, OIL NOZZLES		360	○○○□▽	DISTORTION/WARP CHECK INSPECT FLANGE, ETC.
016		○○○□▽	WAIT 1-1/2 HRS FOR OIL TO LOOSEN NOZZLES		360	●○○□▽	COLD BEND MANIFOLD IF WARPED
020	020	●○○□▽	REMOVE NOZZLE (CA) FM MANIFOLD & CLOS.		365	○○○□▽	VISUALLY INSPECT HEAT SHIELDS / WELDS FOR CRACKS
021		●○○□▽	REMOVE TABLOOTS AND SEALS FROM NOZZLES		368	●○○□▽	SEND TO WELDING FOR CRACK REPAIR, IF REQ
022		●○○□▽	SEPARATE NOZZLES; PLACE IN SHIP. TRAYS			○○○□▽	
030		○○○□▽	VISUALLY INSPECT MANIFOLD & IDENTIFY		370	●○○□▽	CAN PORTS, SECURE BOLTS TO FLANGE ETC.
050	050	●○○□▽	MEASURE INLET FLANGE THICKNESS DIMENSION			●○○□▽	POUNT MANIFOLD ON WOOD SHIPPING BOXES
065	065	●○○□▽	DRILL 4 #55 HOLES IN CLUSTER DUMMY TUBES		380	●○○□▽	COMPLETE SPACER WELDWORK DETS 340
070		●○○□▽	INSTALL RESTRICTIONS IN HEAD; NOZZLE PORTS		390	●○○□▽	TAP MANIFOLD STRAIN PAPER/GIRL
080		●○○□▽	CLEAN MANIFOLD IAW T.O.		400	●○○□▽	CHECK / MAKE UG-10 Q 13 CELL
090		●○○□▽	REMOVE RESTRICTIONS IN NOZZLES / MAKE IT TIGHT			○○○□▽	
100		○○○□▽	HANG IN RACK TO DRY - MIN 8 HRS			○○○□▽	
150		●○○□▽	TRANSFER TO / FROM MACHINE SHOP			○○○□▽	
220	220	○○○□▽	PERFORM MANIFOLD DISTORTION/WARP CHECK			○○○□▽	
221	220	●○○□▽	COLD BEND MANIFOLD IF WARPED			○○○□▽	
222		○○○□▽	INSPECT HEATSHIELDS & WELDS FOR CRACKS			○○○□▽	
	221	○○○□▽	INSPECT FOR NOZZLE CLUSTER DISTORTION			○○○□▽	
		●○○□▽	ALIGN MANIFOLD HEADS			○○○□▽	
	223	●○○□▽	IF FLEX MOUNT MANI: STD TORQUE BOLTS, LOCATING			○○○□▽	
	223	●○○□▽	REPLACE LOOSE / DAMAGED COMBUSTION CHAMBER			○○○□▽	
250		●○○□▽	REMOUNT MANIFOLD ON METAL SHIP FTR.; INSTA			○○○□▽	
260		●○○□▽	BACKSAP: MACHINE AND WELDING SHOPS			○○○□▽	
290	290	●○○□▽	INSPECT NOZZLE BODY SEALS, THREADS, LAP S.			○○○□▽	
300	300	●○○□▽	FLUSH MANIFOLD W/ PU-680			○○○□▽	
	290	○○○□▽	MEASURE NOZZLE GERT DEPTH DIMENSION			○○○□▽	
	310*	●○○□▽	SELECT & INSTALL CORRECT NOZZLES; SEALS; TABLOOTS			○○○□▽	
	330	○○○□▽	IDENTIFY & DOCUMENT VIN / SN OF MANIFOLD			○○○□▽	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

D DELAY

LSC-20147

* INCLUDES WCO OPERATION 320

NOTE: TRANSIT TIMES BETWEEN MOST OPERATIONS ARE LESS THAN 6 MINUTES AND ARE
INCLUDED IN DELAYS

DISASSEMBLY/ASSEMBLY 701-FILE

[illegible]

NOTE: ① NOZZLES REMOVED ARE NOT MATCHED SETS AND ARE NOT REQUIRED TO BE REINSTALLED
IN SAME MANIFOLD FROM WHICH REMOVED.
② NOZZLES ARE INTERCHANGEABLE IN ALL 4 MANIFOLD SECTIONS

OPERATION PROFILE

NAME <u>E. TOTEN</u>		ALC <u>OC</u>		DATE <u>5/9/82</u>		RCC <u>MATPCB</u>		SHEET <u>1</u> OF <u>4</u>					
PCID <u>49810A</u>		WCD <u>CBAATID</u>		WCD DATE <u>88124</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INHOURS % INH.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % INH.	EQUIPMENT CODE	QTY.	TIME REQUIRED % INH.	DATA SOURCE COMMENTS	
00	MAT PCB	IN	1.0	TRANSIT									
				SETUP									
				PROCESS	1.0	36.0							
010		REC	1.0	TRANSIT									
				SETUP									
				PROCESS				1.0	1.0	BEN	1	1.0	1.0
020		PROC	.33	TRANSIT									
				SETUP									
				PROCESS				1	1.0	OC 1132	1	1.0	40
030		PROC	1.0	TRANSIT									
				SETUP									
				PROCESS				1	1.0	OC 1132	1	1.0	1.0
040		PROC	1.0	TRANSIT									
				SETUP									
				PROCESS				1	1.0	BEN	1	1.0	1.0

OPERATION PROC. FILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 3 OF 4			
PCH 4580A		WCD CBEAT 10		WCD DATE 8/17/74							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INQINS % INRS.	SKILL CODE/LEVEL	MAINPOWER QTY.	TIME REQUIRED % INRS.	EQUIPMENT QTY.	TIME REQUIRED % INRS.	DATA SOURCE COMMENTS
050	MAT PCB	PROC	1.0	PROCESS	-	0P09	1	1.0, 20	1132	1.0, 20	
060		PROC	1.0	PROCESS	-		1	1.0, 20	1132	1.0, 20	
070		TEST	1.0	PROCESS	-		1	1.0, 20	1132	1.0, 20	
080		TEST	1.0	PROCESS	-		1	1.0, 12	1132	1.0, 12	
090		TEST	1.0	PROCESS	-		1	1.0, 20	1132	1.0, 20	

OPERATION PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 3 OF 4								
PCN 498104		WCD CBEAT 1.0		WCD DATE _____		MAINPOWER		EQUIPMENT								
OPERATION NUMBER	R/C	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.			%	HRS.			%	HRS.		
100	MAT	PROC	1.0	PROCESS	-	-	DP09	1	1.0	0.02	OC	1132	1	1.0	0.02	
110	PCB	PROC	.80	PROCESS	-	-		1	1.0	4.0	OC	1132	1	1.0	4.0	
120		REP	.80	PROCESS	-	-		1	1.0	0.05	OC	1132	1	1.0	0.05	
130		CLN	1.0	PROCESS	-	-		1	1.0	.80	OC	1132	1	1.0	.80	
140		PROC	1.0	PROCESS	-	-		1	1.0	.01	OC	1132	1	1.0	.01	

OPERATION PR. ILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET <u>4</u> OF <u>4</u>			
PCN _____		NSN _____		PIN <u>49810A</u>		WCD <u>CBE11D</u>		WCD DATE _____			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	
150	MAT PCB	PROC	1.0	PROCESS	—	—	1	1.0	1	1.0	05
160		PW	1.0	PROCESS	—	—	1	1.0	1	1.0	05
170		PW	1.0	PROCESS	—	—	1	1.0	1	1.0	20
9999		Out	1.0	PROCESS	1.0	32.0	—	—	—	—	—

FLOW PROCESS CHART

SUBJECT JS7 MAN. FOLD

DATE 5/7/89

ITEM CODE

WCD CBE4T1

WCD DATE 88174

PCN
HCH
PM

~~49802A~~, ~~49806A~~, ~~49808A~~, 49810A

CHART BEGINS

500 P.P.: MELVIN LOVINGS

CHART ENDS

PREPARED BY E. TOTTEN

[illegible]

○ OPERATION

▽ STORAGE

☐ INSPECTION

▷ TRANSPORTATION

D DELAY

"IN" DATES PROFILE

NAME _____		ALC <u>OC-ALC</u>	DATE <u>31 MAR 89</u>	RCC <u>MRPCB</u>	SHEET <u>1</u> OF <u>1</u>
PCI	PHI	PATIENT WCD DATE _____			
49810A					
OBSERVATION NUMBER	"IG" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	HRS Δ TIME (HRS)		
1	8280	8281	24		
2	8294	8294	0		
3	8298	8299	24		
4	8298	8299	24		
5	8312	8312	0		
6	9023	9024	24		
7	9023	9025	18		
8	9034	9034	0		
9	9037	9038	24		
10	9038	9040	43		
			<u>22</u>		

"OUT" DATES PROFILE

NAME _____ ALC <u>OC-ALC</u> DATE <u>31 MAY 89</u> RCC <u>MTPC B</u> SHEET <u>1</u> OF <u>1</u>			
PCN _____			
RSH _____			
PHI _____			
PARENT WCD _____			
PARENT WCD DATE _____			
OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (DAYS)
1	8298	8298	0
2	8314	8315	24
3	8320	8320	0
4	8319	8321	48
5	8333	8333	0
6	9044	9045	24
7	9045	9045	0
8	9055	9058	72
9	9058	9058	0
10	9060	9061	24
			(20)

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATION PROFILE

NAME <u>E. TOTTEN</u>		ALC <u>OC</u>		DATE <u>5/16/89</u>		RCC <u>MATPCB</u>		SHEET <u>3</u> OF <u>4</u>					
ITEM CODE <u>50067A</u>		WCD <u>CBEM29</u>		WCD DATE <u>88/80</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MAINPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.		EQUIPMENT CODE	QTY.	TIME REQUIRED %
081	MAT PCB	DEL	1.0	TRANSIT	10	1.05		201			HOW MANY REPLACES NEW PARTS TLC PARTS TO GO TO RT UNABLE TO REPLACES		
				SETUP	50	48							
				PROCESS	40	112							
082		MOVE	1.0	TRANSIT	100	0.1	EP09				MOVE PARTS TO TEST BAG		
				SETUP									
				PROCESS									
085	MAT PCB (TEST)	ASSY	1.0	TRANSIT	100	0.1	EP09	001	100	0.1	100	0.1	ASSEMBLE FEED PARTS PARTS @ TEST STARTED 3-1-85 AFTER 3-1-85 (DONT INDICATE)
				SETUP									
				PROCESS									
090		TEST	0.05	TRANSIT	100	1.2						BATCH 20 TEST AS VALUE ASSEMBLY DONE 15 WKT. A FORMER CHANGE ADDRESS 35 ADDRESS IN PARTS IN CBEM 29 (LINE TRANSIT)	
				SETUP									
				PROCESS									
100		PCB	0.05	TRANSIT	100	0.1						PHOTOGRAPH VALUE ADDRESS ALONG ADDRESS ADDRESS ADDRESS	
				SETUP									
				PROCESS									

OPERATION PROFILE

NAME <u>E. TOTTEN</u>		ALC <u>OC</u>		DATE <u>5/16/89</u>		RCC <u>MA77CB</u>		SHEET <u>4</u> OF <u>4</u>												
ITEM CODE <u>50067A</u>		WCD <u>C8EM29</u>		WCD DATE <u>88180</u>																
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			TIME REQUIRED HRS.	DATA SOURCE COMMENTS							
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %									
110	MAT 0000 (0/11)	PW	1.0	TRANSIT	100 0.05	BP 19	001	100	005	BGN43	001	100	0.05	MADE REPAIRS PERFORMED AND NOT REPAIRED WILE BE MAINT 2 A.M. ON 11/18/88						
				SETUP																
				PROCESS																
120	PW	PW	1.0	TRANSIT	100 0.05	PW	001	100	005	BGN43	001	100	0.05	REPAIRS						
				SETUP																
				PROCESS																
130	PW	PW	1.0	TRANSIT	100 0.05	PW	001	100	005	BGN43	001	100	0.05	REPAIRS						
				SETUP																
				PROCESS																
9999	PW	PW	1.0	TRANSIT	100 0.05	PW	001	100	005	BGN43	001	100	0.05	REPAIRS						
				SETUP																
				PROCESS																

30, 31, 29

517-1517
2605 1907
572208
OVER 1112

OPERATION PROFILE

OPERATION PROFILE													
NAME <u>E. TOTTEN</u>		ALC <u>OC</u>		DATE <u>5/11/69</u>		RCC <u>MAT PCB</u>		SHEET <u>1</u> OF <u>7</u>					
ITEM CODE <u>50067A</u>		WCD <u>CBEM30</u>		WCD DATE <u>88/80</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED %	HRS.	DATA SOURCE COMMENTS
							QTY.	%	QTY.	%			
1/N	MATP CB	IN DATE	1.0	TRANSIT									DATE MATP/CB
005	MAT PCB	REC	.7	TRANSIT	2.0	BPO7	001	25	1	25	2.0		NOTES FROM SIMPLY ADDRESS IN BLOC 3123. DOES NOT INCLUDE THOSE FROM ENGINE LINE. PARTIAL 1000 OR 10000000
				SETUP	1.0	↓	↓	75	1	75	1.0		
				PROCESS									
008		MAJUC	.7	TRANSIT	0.1	BPO7	001	100	0.1	100	0.1		MAJUC MATP/CB TO CHOP IN BLOC 3123
				SETUP									
				PROCESS									
010		REC	1.0	TRANSIT	0.2	BPO7	001	100	0.2	100	0.2		NOTES FROM ENGINE LINE ("PARTIAL") APPROX AT 5000 ENTER FM 5100 3123 FM 5100
				SETUP									
				PROCESS									REMARKS OUT CASE STREET AND ORIGINAL
015		015	1.0	TRANSIT	0.02	BPO7	001	100	0.02	100	0.02		DISASSURABLE VALUE END, REMARKS VALUE
				SETUP									REMARKS, REMARKS
				PROCESS									CAD. (REX INFORMATIONAL MATP/CB)

$\left\{ \begin{array}{l} \text{المشقة} \\ \text{التي هي} \\ \text{منه} \end{array} \right.$

OPERATION PROFILE

NAME <u>E. TETEN</u>		ALC <u>OC</u>		DATE <u>5/15/89</u>		RCC <u>MAT PCB</u>		SHEET <u>2</u> OF <u>7</u>						
ITEM CODE <u>NON</u>		PIN <u>50067A</u>		WCD <u>CBEM30</u>		WCD DATE <u>88/80</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.			
020	MAT RAB	CLN	1.0	TRANSIT SETUP PROCESS	0.3	B/P09	001	100	0.1	0C4747	001	100	0.25	DECKED IN TO REWORK FIRE EXTERNAL CLO.
021		WOC		TRANSIT SETUP PROCESS	0.02	B/P07	001	100	0.02	BENUS	001	100	0.02	IF IMPROVE MODIFICATION, THEN NEW NUMBERS OF MATIC (SEE MATRIC)
022		PA	1.0	TRANSIT SETUP PROCESS	0.2	B/P09	001	100	0.2	BENUS	001	100	0.2	COMPLETE PREPARED REPAIR POWER TO MACHINE SHOP (QUICKEN, 750, MACHINE 5-40 L201) (FOR 00102225)
040	MAT PCM	PROC	1.0	TRANSIT SETUP PROCESS	4.0 6.0			20 80						POWER TO MACHINE SHOP FOR TP REWORK/REPAIR. PER. CHIN 29
050	MAT PCB	CLN	1.0	TRANSIT SETUP PROCESS	1.1	B/P09	001	100	0.1	0C3024	001	100	1.0	BACKS HOP CLEAN MATRIC IN AFTER MACHINE SHOP INTERNAL MATIC OF 10, TOTAL 20 MAT.

B/S

OPERATION PROFILE

NAME <u>E. TOTTEN</u>		ALC <u>OC</u>		DATE <u>5/15/89</u>		RCC <u>MAT PCB</u>		SHEET <u>8</u> OF <u>7</u>						
ITEM CODE <u>50067A</u>		WCD <u>CDEM 30</u>		WCD DATE <u>88/80</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	%	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.			%
051	MAT PCB	CLN	1.0	TRANSIT SETUP PROCESS	0.25	0409	201	100	0.05	OC 4133	201	100	0.25	Cold water RINSE
052			1.0	TRANSIT SETUP PROCESS	1.0			100	0.05	OC 4137	201	100	1.0	ALKALI
053			1.0	TRANSIT SETUP PROCESS	0.25			100	0.05	OC 4134	201	100	0.25	Cold H ₂ O RINSE
054			1.0	TRANSIT SETUP PROCESS	0.5			100	0.05	OC 4140	201	100	0.5	Song 1.5 liter 8.76
055			1.0	TRANSIT SETUP PROCESS	0.25			100	0.1	OC 4132	201	100	0.25	H ₂ O Cold RINSE

OPERATION PROFILE

NAME <u>E. TOTTEN</u>		ALC <u>OC</u>		DATE <u>5/15/89</u>		RCC <u>MAT PCB</u>		SHEET <u>5</u> OF <u>7</u>						
ITEM CODE <u>50067A</u>		WCD <u>CDEM30</u>		WCD DATE <u>88/80</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	QTY.	EQUIPMENT CODE		TIME REQUIRED %	TIME REQUIRED HRS.
080	MAT PCB	ASSY	1.0	TRANSIT	1.0	8P09	001	100	1.0	1	BEN45	100	1	BATCHED IN TO QUANTITY OF 20.
090		INSP	1.0	TRANSIT	0.1			100	0.1	001	6963659	100	0.1	BATCHED IN TO QUANTITY OF 20.
100		MOVE	1.0	TRANSIT	0.05			100	0.05					ALIGNMENT FUTURE
110	MAT PCB	PROC	1.0	TRANSIT	5.0									WELD TYP TO HOUSING
120	MAT PCB	INSP	1.0	TRANSIT	0.2	8P09	001	100	0.2	001	6963659	100	0.1	BATCHED IN TO QUANTITY OF 20.

63/5

OPERATION PROFILE

NAME <u>E. TOTTEN</u>		ALC <u>OC</u>		DATE <u>5/5/89</u>		RCC <u>MAT PCB</u>		SHEET <u>4</u> OF <u>7</u>					
ITEM CODE <u>50067A</u>		WCD <u>CDEM30</u>		WCD DATE <u>88/80</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			TIME REQUIRED HRS.	DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	%	TIME REQUIRED HRS.	QTY.	%		
130	MAT PCB	MOVE	1.0	TRANSIT	0.1	B109	001	100	1				RANGE TO 3/48 FOL TEST
				SETUP									
				PROCESS									
140	MAT PCB (TEST)	ASSY	1.0	TRANSIT		0P09	001	100	1	BENHS	1	100	ASSMBL UNOF ASSMBL INW CHEN 29
				SETUP									
				PROCESS									
150	↓	ASSY	1.0	TRANSIT		0P09	001	100	1	BENHS	1	100	FAME ASSMBL
				SETUP									
				PROCESS									
160	↓	PW	1.0	TRANSIT		0P09	001	100	1	BENHS	1	100	ATTACH PAPERWORK
				SETUP									
				PROCESS									
175	MAT PCB	PROC	0.6	TRANSIT	0.25	B009	001	100	0.25	BENHS	001	100	IN STAIL RISET (PIN) IN 2/5 MOD NOTPES.
				SETUP									
				PROCESS									

B/S
TEST

[illegible]

FLOW PROCESS CHART

SUBJECT

DATE

ITEM CODE

WCD CBEM30

WCD DATE 88/80

PCH
KSY
PM

0000

50067A

005

DATE 8/14/89

CHART BEGINS

CHART ENDS

PREPARED BY E. TOTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
105		●○○□▽	REC 2473	210	210	●○○□▽	SECL
200		○●○○□▽	POW. SUPPLY VOLT. TO 200V			○●○○□▽	
010	010	●○○□▽	DR. 100V 2 500V			○●○○□▽	
015		●○○□▽	DR. 100V 2 500V			○●○○□▽	
020		●○○□▽	DR. 100V 2 500V			○●○○□▽	
021		●○○□▽	ETCH NUMBERS			○●○○□▽	
022		●○○□▽	WASH. 100V			○●○○□▽	
040		●○○□▽	MACHINES - P			○●○○□▽	
110		●○○□▽	CLEAN INTERNAL ACID			○●○○□▽	
151		●○○□▽	COLD H2O RINSE			○●○○□▽	
152		●○○□▽	WASH WASH			○●○○□▽	
153		●○○□▽	COLD H2O RINSE			○●○○□▽	
154		●○○□▽	HOT DRY H2O			○●○○□▽	
155		●○○□▽	COLD H2O RINSE			○●○○□▽	
156		●○○□▽	HOT AIR DRY			○●○○□▽	
157		○●○○□▽	FPI TEST			○●○○□▽	
158		●○○□▽	INSTALL COVER GASKET			○●○○□▽	
159		●○○□▽	ROCKING MACHINES (FLOW) TEST			○●○○□▽	
060	060	●○○□▽	WASH MEASURE S4001000K			○●○○□▽	
080	080	●○○□▽	ASSEMBLY			○●○○□▽	
090	090	○●○○□▽	ALIGNMENT CHECK			○●○○□▽	
100	100	○●○○□▽	MOVE TO WELDING			○●○○□▽	
110	110	●○○□▽	WELD TIP TO WELDING			○●○○□▽	
120	120	○●○○□▽	POST WELD ALIGN. CHECK			○●○○□▽	
130	130	○●○○□▽	ROUTE TO 200V FOR TEST			○●○○□▽	
140	140	●○○□▽	ASSEMBLE UNIKALY			○●○○□▽	
150	150	●○○□▽	FINAL ASSY.			○●○○□▽	
160	160	●○○□▽	WASHDOWN			○●○○□▽	
175		●○○□▽	INSTALL DIPST N L/S MOOS			○●○○□▽	
180	180	○●○○□▽	INSTALL DIPST N L/S MOOS			○●○○□▽	
190	190	●○○□▽	WASHDOWN			○●○○□▽	
200	200	●○○□▽	WASHDOWN			○●○○□▽	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

D DELAY

LSC-20147

OPERATIONAL PROFILE

NAME PHUNT ALC OC DATE 06/5/89 RCC MA-PCB SHEET 1 OF 6

PCN 50067A WCD CBEM31 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	%	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	%	HRS.	
00	MATP CB	IN DATE	1.0	TRANSIT										
				SETUP										
				PROCESS	20									
10	MATP CB	REC.	1.0	TRANSIT										REC., ID, PW
				SETUP										
				PROCESS		DP09	1	100	.16	0C4278	1	100	.16	
15	MATP CB	PROC	1.0	TRANSIT										SET-UP, TIG, CAPS, PUT IN, PROC. ETC.
				SETUP										
				PROCESS		DP09	1	100	.25	0C4278	1	100	.25	
20	MATP CB	TEST	1.0	TRANSIT										PRESSURE TEST SUBADY.
				SETUP										
				PROCESS		DP09	1	100	.05	0C4278	1	100	.05	
21	MATP CB	PROC	1.0	TRANSIT										
				SETUP										
				PROCESS		DP09	1	100	.10	0C4278	1	100	.15	

OPERATION PROFILE

NAME PHUNT ALC OC DATE 061584 RCC MATPCB SHEET 2 OF 6

PCN 50067A WCD CBCM31 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.			%	HRS.			%	HRS.	
22	MATP CB	TEST	1.0	TRANSIT											CLEAN, TEST
				SETUP											
				PROCESS			DP09	1	100	.17	0C4278	1	100	.25	
30	MATP CB	TEST	1.0	TRANSIT											LEAK TEST
				SETUP											
				PROCESS			DP09	1	100	.25	0C0952	1	100	.25	
40	MATP CB	TEST	1.0	TRANSIT											PRESSURE TEST HOUSING
				SETUP											
				PROCESS			DP09	1	100	.10	0C4278	1	100	.10	
55	MATP CB	PROC	1.0	TRANSIT											BUILD VALVE ASSY
				SETUP											
				PROCESS			DP04	1	100	.17	0C4278	1	100	.17	
60	MATP CB	PROC	1.0	TRANSIT											REPAIR OIL LINE
				SETUP											
				PROCESS			DP04	1	100	.17	0C4278	1	100	.17	

OPERATION PROFILE

NAME PHUNT ALC OC DATE 061589 RCC MATPCB SHEET 3 OF 6

PCN 50067A WCD CBEM31 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
70	MATP CB	TORQ	1.0	TRANSIT							SEC OP. 55
		SETUP									
		PROCESS				1	100	004278	1	100	0
80	MATP CB	TEST	1.0	TRANSIT							RECHECK PINNACLE NUT
		SETUP									
		PROCESS				1	100	004278	1	100	.05
90	MATP CB	TORQ	1.0	TRANSIT							TORQUE LINER
		SETUP									
		PROCESS				1	100	004278	1	100	.05
100	MATP CB	INSP.	1.0	TRANSIT							INSPECTION CHART
		SETUP									
		PROCESS				1	100	004278	1	100	.05
110	MATP CB	PROC	1.0	TRANSIT							INSPECTION CHART
		SETUP									
		PROCESS				1	100	004278	1	100	.05

OPERATION PROFILE

NAME <u>P HUNT</u>		ALC <u>OC</u>		DATE <u>061589</u>		RCC <u>MATPCB</u>		SHEET <u>4 of 6</u>						
PCN <u>50067A</u>		WCD <u>CBEM31</u>		WCD DATE <u>89094</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MANPOWER			EQUIPMENT			TIME REQUIRED % HRS.	DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	% HRS.	EQUIPMENT CODE	QTY.	% HRS.			
120	MATPCB	TEST	1.0	TRANSIT									FLOW TEST	
				SETUP										
				PROCESS										
						DP09	1	100	.33	OC4278	1	100	.33	
130	MATPCB	Info.	1.0	TRANSIT									INFO ONLY	
				SETUP										
				PROCESS										
						DP09	1	100	N/A	N/A	1	N/A	N/A	
140	MATPCB	TEST	1.0	TRANSIT									SPRAY ANGLE TEST	
				SETUP										
				PROCESS										
						DP09	1	100	.03	OC4278	1	100	.03	
150	MATPCB	TEST	1.0	TRANSIT									Secondary flow pattern TEST	
				SETUP										
				PROCESS										
						DP09	1	100	.10	OC952	1	100	.10	
160	MATPCB	TEST	1.0	TRANSIT									STATIC pressure TEST	
				SETUP										
				PROCESS										
						DP09	1	100	.12	OC4278	1	100	.12	

OPERATING PROFILE

NAME <u>PHUNT</u> ALC <u>DC</u> DATE <u>061589</u> RCC <u>MAPPCB</u> SHEET <u>5</u> OF <u>6</u>		WCD <u>CBUM31</u> WCD DATE <u>89094</u>		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.			%	HRS.	
170	MAP CB	TEST	1.0	TRANSIT											VALVE LEAK TEST
				SETUP											
				PROCESS			DP04	1	100	.05	0C4743	1	100	.05	
180	MAP CB	TEST	1.0	TRANSIT											ALL TEST OPS COMPL.
				SETUP											
				PROCESS			DP04	1	100	.07	0C4743	1	100	.07	
190	MAP CB	WRE	1.0	TRANSIT											
				SETUP											
				PROCESS			DP04	1	100	.13	0C4743	1	100	.11	
200	MAP CB	PW	1.0	TRANSIT											
				SETUP											
				PROCESS			DP04	1	100	.13	0C4743	1	100	.17	
210	MAP CB	PW	1.0	TRANSIT											
				SETUP											
				PROCESS			DP04	1	100	.03	0C4743	1	100	.17	

OPERATION PROFILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>061589</u>		RCC <u>MAIPCB</u>		SHEET <u>6</u> OF <u>6</u>						
PCN <u>50067A</u>		WCD <u>CBUM31</u>		WCD DATE <u>89094</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED	DATA SOURCE COMMENTS		
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.			EQUIPMENT CODE	QTY.
9944	MAIPCB	OUT DATE	1.0	TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

FLOW PROCESS CHART

SUBJECT 50067A

DATE 061589

ITEM CODE
PCH
NOM.
P/M

WCD CBCM 31 WCD DATE 89094

CHART BEGINS 10 REC

CHART ENDS 210 PW

PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●○○□▽	REC			○○○□▽	
15	15	●○○□▽	SCT-UP			○○○□▽	
20	20	○○○□▽	PRESS TEST			○○○□▽	
21	21	●○○□▽	PROC			○○○□▽	
22	22	○○○□▽	CLAMP, TEST			○○○□▽	
30	30	○○○□▽	LEAK TEST			○○○□▽	
40	40	○○○□▽	PRESSURE TEST			○○○□▽	
55	55	●○○□▽	BUILD VALVE TEST			○○○□▽	
60	60	●○○□▽	PROC.			○○○□▽	
70	70	●○○□▽	TORQ.			○○○□▽	
80	80	○○○□▽	TEST			○○○□▽	
90	90	●○○□▽	TORQUE			○○○□▽	
100	100	○○○□▽	INSPECT CAVITY			○○○□▽	
110	110	●○○□▽	INSTALL NEW GASKET.			○○○□▽	
120	120	○○○□▽	FLW TEST			○○○□▽	
130	130	●○○□▽	INFO.			○○○□▽	
140	140	○○○□▽	SPRAY ANGLE TEST			○○○□▽	
150	150	○○○□▽	SECONDARY SPRAY PATTERN			○○○□▽	
160	160	○○○□▽	STATIC PRESS. TEST			○○○□▽	
170	170	○○○□▽	VALVE LEAK TEST			○○○□▽	
180	180	●○○□▽	BL TEST OPS COMPLE			○○○□▽	
190	190	●○○□▽	SAFETY WIND			○○○□▽	
200	200	●○○□▽	PW COMPLE.			○○○□▽	
210	210	●○○□▽	PW			○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

◇ DELAY

LSC-20147

"IN" DATES PROFILE

NAME <u>ALC OC-ALC</u>		DATE <u>31 MAY 89</u>	RCC <u>MTPCB</u>	SHEET <u>1</u> OF <u>1</u>
PCH <u>50067A</u>		PATIENT WCD <u> </u>		
PATIENT WCD <u> </u>		PATIENT WCD DATE <u> </u>		
OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	HRS Δ TIME (HRS)	
1	8298	8298	0	
2	8298	8299	24	
3	8305	8306	24	
4	8305	8307	48	
5	8319	8319	0	
6	8319	8319	0	
7	8333	8334	24	
8	8333	8334	24	
9	8333	8335	48	
10	9010	9010	0	
			(20)	

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING ERRORS IN BLOCK 5 OF WCD ON DATE

"OUT" DATES PROGRAM

NAME _____		ALC <u>OC-ALC</u>	DATE <u>3/14/89</u>	RCC <u>MTFCB</u>	SHEET <u>1</u> OF <u>1</u>
PCI	ISI	PHI	PATIENT WCD	PATIENT WCD DATE	
50067A					
OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	TIME (HRS)		
1	8300	8300	0		
2	8307	8307	0		
3	8309	8312	" 72		
4	8309	8319	240		
5	8322	8323	24		
6	8321	8321	0		
7	8336	8337	24		
8	8342	8342	0		
9	8337	8340	72		
10	9012	9012	0		
			(44)		

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 5-30-89 RCC MTPCT SHEET 4 OF 4

PCN 50134A WCD CBET10 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANIPULATOR			EQUIPMENT			DATA SOURCE COMMENTS
					%	INS.		QTY.	%	INS.	EQUIPMENT CODE	QTY.	%	INS.
00	MTP CT	IN DATE	1.0	TRANSIT										
				SETUP										
				PROCESS										
10	MTP CT	TEST	1.0	TRANSIT										BREAK-IN RUN ON HYDRAULIC TEST STAND
				SETUP										
				PROCESS				DP09	100	.33	0C948	1	100	.33
20	MTP CT	TEST	1.0	TRANSIT										T.O. CALLS FOR 3 MIN. DOW FROM 63 MIN.
				SETUP										
				PROCESS				DP09	100	.75	0C948	1	100	.75
030	MTP	TEST	1.0	TRANSIT										PART OF OP. 020
				SETUP										
				PROCESS				DP09	100	0	0C948	1	100	0
040	MTP	TEST	1.0	TRANSIT										25% fan hour
				SETUP										
				PROCESS				DP09	100	.17	0C948	1	100	.17

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 5-30-89 RCC MTPCT SHEET 2 OF 4

PCN
NSH
PHI

50134A

WCD CBEY10

WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.
045	MTP CT	RCP.	.25	TRANSIT										
				SETUP										
				PROCESS			DP09	1	25	.25	0C948	1	100	.33
050	MTP CT	TEST	1.0	TRANSIT										
				SETUP										
				PROCESS			DP09	1	100	.17	0C948	1	100	.17
055	MTP CT	TEST	1.0	TRANSIT										
				SETUP										
				PROCESS			DP09	1	100	.25	0C948	1	100	.25
060	MTP CT	TEST	1.0	TRANSIT										
				SETUP										
				PROCESS			DP09	1	100	.33	0C948	1	100	.33
075	MTP CT	TEST	1.0	TRANSIT										
				SETUP										
				PROCESS			DP09	1	100	.17	0C948	1	100	.17

TEST STAND
OPERATOR
CALLS MECHANIC
TO REPAIR
UNIT ON SLAT
STAND. SEAL

SET full
flow

INTERNAL
LEAK
CHECKS

PORT.
CALIB.
TEST

HISTORICAL
LIMITS
TESTS

OPERATION: CFILE

NAME <u>P. HUNT</u>		ALC <u>OC</u>		DATE <u>5-30-89</u>		RCC <u>MTPCT</u>		SHEET <u>3</u> OF <u>4</u>			
ECN <u>50134A</u>		WCD <u>CBEY10</u>		WCD DATE <u>89094</u>							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % INHS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % INHS.	EQUIPMENT QTY.	TIME REQUIRED % INHS.	DATA SOURCE COMMENTS
080	MTP CT	TEST	0	TRANSIT							IS ARE SET ON TEST STAND
				SETUP							
				PROCESS							
090	MTP CT	TEST	1.0	TRANSIT							CYCLE TEST
				SETUP							
				PROCESS							
110	MTP CT	TEST	1.0	TRANSIT							5070 REJECT AT THIS POINT. CONTACT BUNCH MECHANIC.
				SETUP							
				PROCESS							
115	MTP CT	REP	.5	TRANSIT							REPAIR PROBLEMS WITH UNIT WHICH ON TEST STAND
				SETUP							
				PROCESS							
120	MTP CT	TEST	1.0	TRANSIT							OIL FLUSH
				SETUP							
				PROCESS							

OPERATION FILE

NAME <u>P. HUNT</u>		ALC <u>OC</u>		DATE <u>5-30-89</u>		RCC <u>MTPCT</u>		SHEET <u>4</u> OF <u>4</u>			
PCN <u>50134A</u>		WCD <u>CBEY10</u>		WCD DATE <u>89094</u>							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MAIN POWER SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT EQUIPMENT CODE QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
125	MTP CT	WRE	1.0	TRANSIT							LOCKWIRE
				SETUP							
				PROCESS							
130	MTP CT	PW	1.0	TRANSIT		DP09	1	100 .15	00948 1	100 .15	
				SETUP							
				PROCESS							
140	MTP CT	PW	1.0	TRANSIT		DP09	1	100 .17	00948 1	100 .17	
				SETUP							
				PROCESS							
150	MTP CT	MOV	1.0	TRANSIT		DP09	1	100 0	00948	0	
				SETUP							
				PROCESS							
9909	MTP CT	OUT DATE	1.0	TRANSIT		DP09	1	100 .17			RET. TO ASBY MECHANIC
				SETUP							
				PROCESS							

SUBJECT PUMP, HYD. FUEL **FLOW PROCESS CHART**

DATE 5-30-89

ITEM CODE

PCX
KOK.
P/M

WCD CBEY 10

WCD DATE 88188

CHART BEGINS 010 ~~BREAK IN RECORD~~

CHART ENDS: 150 MOVE TO FINAL ASSY

PREPARED BY P. Hunt

[illegible]

○ OPERATION

▷ TRANSPORTATION

▽ STORAGE

D DELAY

☐ INSPECTION

OPERATION PROFILE

NAME <u>P. Hunt</u>		ALC <u>OC</u>		DATE <u>5-30-89</u>		RCC <u>MATPCA</u>		SHEET <u>1</u> OF <u>6</u>		
PCN <u>50134A</u>		WCD <u>CBY11</u>		WCD DATE <u>88269</u>						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	
00	MATP CB	IN DATE	1.0	TRANSIT	32					
				SETUP						
				PROCESS						
10	MATP CB	PW	1.0	TRANSIT						PREPARE PARAPLANE
				SETUP						
				PROCESS						
11	MATP CB	INSP	1.0	TRANSIT						VISUAL INSPECT HOUSING
				SETUP						
				PROCESS						
12	MATP CB	REFL	.07	TRANSIT						7% NEED HOUSING REFL SUPPORT MARKING SHEET
				SETUP						
				PROCESS						
15	MATP CB	CLN	1.00	TRANSIT						CLN EXTENDING.
				SETUP						
				PROCESS						

OPERATION PROFILE

NAME P. H. J. A. ALC OC DATE 5-30-89 RCC MATPCB SHEET 2 OF 6

WCD CBET 11 WCD DATE 88267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MAIPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	INS.		QTY.	%	EQUIPMENT CODE	QTY.	
20	MATP CB	DIS	1.0	TRANSIT								DISCARD O-RINGS, SPRINGS, PISTONS + DO VISUAL INSPECT.
				SETUP								
				PROCESS				1	100	BEN423	1	
30	MATP CB	CLN	1.0	TRANSIT								DISCARD
				SETUP								
				PROCESS				1	100	OC 4947	1	
40	MATP CB	INSP.	1.0	TRANSIT								VISUAL INSPECTION TEST
				SETUP								
				PROCESS				1	100	BEN423	1	
50	MATP CB	NDI	1.0	TRANSIT								FACIL, PEN, INSPE.
				SETUP								
				PROCESS	100			1	100	1100148	1	
60	MATP CB	NDI	1.0	TRANSIT								MAG INSPECTION
				SETUP								
				PROCESS	100	24		1	100	1100148	1	

OPERATION PROFILE

NAME <u>P. H. J.</u>		ALC <u>OC</u>		DATE <u>5-30-89</u>		RCC <u>MATPCB</u>		MTPCB <u>SHEET 3 OF 6</u>					
PCU P/H		50134A		WCD <u>CBET 11</u>		WCD DATE <u>88267</u>							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			TIME REQUIRED HRS.	DATA SOURCE COMMENTS
						SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		
070	MATP CB	REP.	1.0	TRANSIT									BEARING MARKINGS ARE TOO SMALL TO READ.
				SETUP									
				PROCESS									
075	MATP CB	REP.	1.0	TRANSIT									IMPELLOR MOD.
				SETUP									
				PROCESS									
080	MATP CB	REAL.	1.0	TRANSIT									PIT HAS NEW SPACER SO ALL SPRINGS REPLACED BECAUSE OF PIT.
				SETUP									
				PROCESS									
090	MATP CB	ASSY	1.0	TRANSIT									SELECT FIT BEARING INTO PUMP HOUSING
				SETUP									
				PROCESS									
100	MATP CB	ASSY	1.0	TRANSIT									ASSY PUMP
				SETUP									
				PROCESS									

OPERATION PROFILE

NAME <u>P. HUNT</u>		ALC <u>OC</u>		DATE <u>5-30-89</u>		NCC <u>MATPCB</u>		MTPCB SHEET <u>4</u> OF <u>6</u>					
PCN <u>50134A</u>		WCD <u>CBET 11</u>		WCD DATE <u>88267</u>									
OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE		QTY.	%
110	MATP CB	ASSY	100	TRANSIT								INSTALL ALL NEW SPRINGS.	
				SETUP									
				PROCESS									
120	MATP CB	ASSY	100	TRANSIT								ASSY REPAIR CO-102 ASSEMBLY.	
				SETUP									
				PROCESS									
130	MATP CB	ASSY	100	TRANSIT								ASSY SPOOL Y SLEEVES ASSEMBLY.	
				SETUP									
				PROCESS									
140	MATP CB	ASSY	100	TRANSIT								ASSY IMPELLOR Y PART CO-102 TO HOUSING.	
				SETUP									
				PROCESS									
150	MATP CB	PW	100	TRANSIT								C/W TO CO-102.	
				SETUP									
				PROCESS									

OPERATION PROFILE

NAME <u>P. HUNT</u>		ALC <u>OC</u>		DATE <u>5-30-89</u>		RCC <u>MATPCB</u>		SHEET <u>5</u> OF <u>6</u>							
PCH TST PH		50134A		WCD <u>CBET 11</u>		WCD DATE <u>88267</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT			DATA SOURCE COMMENTS			
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE		QTY.	%	HRS.
160	MATP CB	PW	1.0	TRANSIT			BP09	1	100	.17	BEN433	1	100	.17	C/W OK TO
				SETUP											
				PROCESS											
170	MATP CB	PW	1.0	TRANSIT			BP09	1	100	.17	BEN433	1	100	.17	DATA PLATE MADE CORRECT
				SETUP											
				PROCESS											
180	MATP CB	TEST	1.0	TRANSIT			BP09	1	100	.17	BEN433	1	100	.17	MOVE TO BUDG. 3108 TEST
				SETUP											
				PROCESS											
190	MATP CB	WARE	1.0	TRANSIT		100	24	1	100	.17	NA	NA	NA	NA	
				SETUP											
				PROCESS											
200	MATP CB	PW		TRANSIT			BP09	1	100	.25	BEN433	1	100	.25	
				SETUP											
				PROCESS											
				TRANSIT			BP09	1	100	.08	BEN433	1	100	.08	
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME <u>P. HUNT</u>		ALC <u>OC</u>		DATE <u>5-30-89</u>		RCC <u>MATPCB</u>		MTPCB SHEET <u>6 OF 6</u>							
PCN <u>50134A</u>		WCD <u>C367 11</u>		WCD DATE <u>88267</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MAIN POWER			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.
210	MATP CB	PW	1.0	TRANSIT											
				SETUP											
				PROCESS											
9999	MATP CB	OUT DATE	1.0	TRANSIT			BPO9	1	100	08	BEN431	1	100	08	
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

DISASSEMBLY/ASSEMBLY PROFILE

NAME P. Hunt

ALC OC

DATE 053089

RCC WTPCB

SHEET 1 OF 2

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED R/O ASST. Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHLD WCD	CHLD WCD DATE	
PCN NSH PIN 50134A	CBE711	89094	020	140	PCN NSH PIN 02-14151	CBE711S1		Y
PCN NSH PIN					PCN NSH PIN 102-11046	S2		Y
PCN NSH PIN					PCN NSH PIN 02-14563-02	S3		Y
PCN NSH PIN					PCN NSH PIN 02-14581-02	S4		Y
PCN NSH PIN					PCN NSH PIN 102-1160-12	S5		Y
PCN NSH PIN					PCN NSH PIN 02-14561-02	S6		Y
PCN NSH PIN					PCN NSH PIN 02-14543-16	S7		Y
PCN NSH PIN					PCN NSH PIN 02-14567-04	S8		Y
PCN NSH PIN					PCN NSH PIN 02-14694-02	S9		Y
PCN NSH PIN					PCN NSH PIN 02-14565-01	S10		Y
PCN NSH PIN					PCN NSH PIN 102-1554	S11		Y
PCN NSH PIN					PCN NSH PIN 02-14385	S12		Y

LSC-20WJSA

FILE

MSC-2(XM)SA

MSC-2(XM)SA

SUBJECT PUMP-HY FUEL **FLOW PROCESS CHART** DATE 53089

ITEM CODE

PCH

NCH

PM

WCD

CBE711

WCD DATE

88267

CHART BEGINS

010 RECEIVE

CHART ENDS

210 - PW CLW TO

PREPARED BY

P. HUNT

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●○○□▽	RECEIVE			○○○□▽	
15	—	●○○□▽	CLN. PD680			○○○□▽	
20	20	●○○□▽	DISASSY			○○○□▽	
30	30	●○○□▽	CLN			○○○□▽	
40	40	○○○□▽	VISUAL INSP.			○○○□▽	
50	50	○○○□▽	NDI, TIOA PEN INSP.			○○○□▽	
60	60	○○○□▽	NDI, MAG PARTICLES INSP.			○○○□▽	
70	70	●○○□▽	REPAIR+REPL			○○○□▽	
75	75	●○○□▽	IMPELLOR MOD			○○○□▽	
80	80	○○○□▽	CHK SPANG.			○○○□▽	
90	90	●○○□▽	ASSY BRNG.			○○○□▽	
100	100	●○○□▽	ASSY PISTONS			○○○□▽	
110	110	●○○□▽	ASSY RET. SPRINGS			○○○□▽	
120	120	●○○□▽	ASSY RET. CURVE R			○○○□▽	
		○○○□▽				○○○□▽	
130	130	●○○□▽	ASSY SPOOL+SLURVE			○○○□▽	
140	140	●○○□▽	ASSY IMPELLOR 2			○○○□▽	
150	150	●○○□▽	PW - G/W TO 10. LIM.			○○○□▽	
155	155	●○○□▽	RETORQUE			○○○□▽	
160	160	●○○□▽	PW			○○○□▽	
170	170	●○○□▽	CORRECT DATA PLATE			○○○□▽	
180	180	○○○□▽	MOVE TO B106308 TEST			○○○□▽	
190	190	●○○□▽	WIRE-SAFETY			○○○□▽	
200	200	○○○□▽	INSP. + PW			○○○□▽	
210	210	●○○□▽	PW - CLW MAGI 66-36			○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	
		○○○□▽				○○○□▽	

○ OPERATION

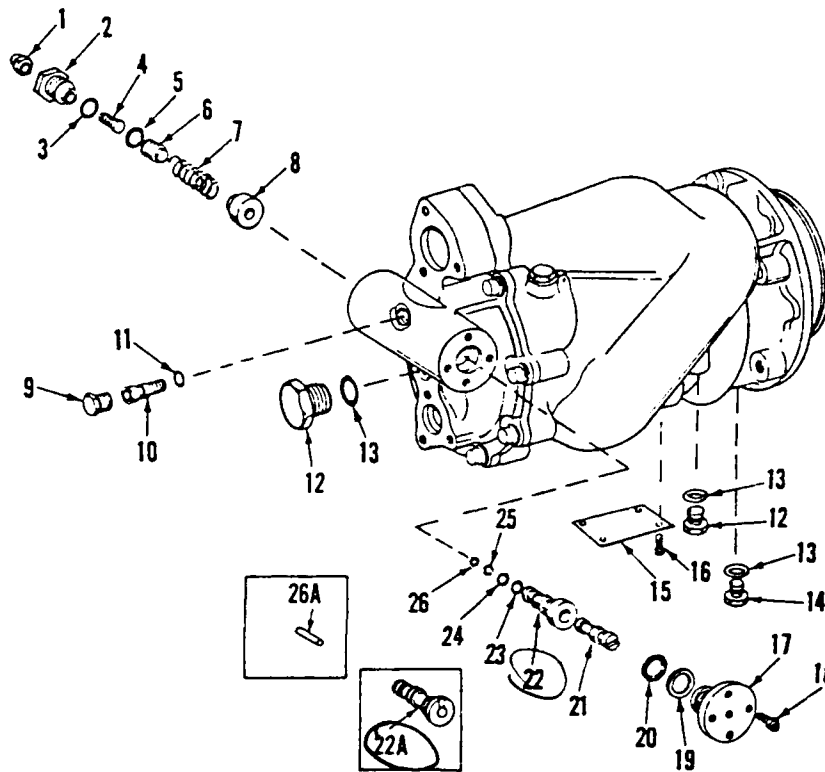
◇ TRANSPORTATION

▽ STORAGE

⊔ DELAY

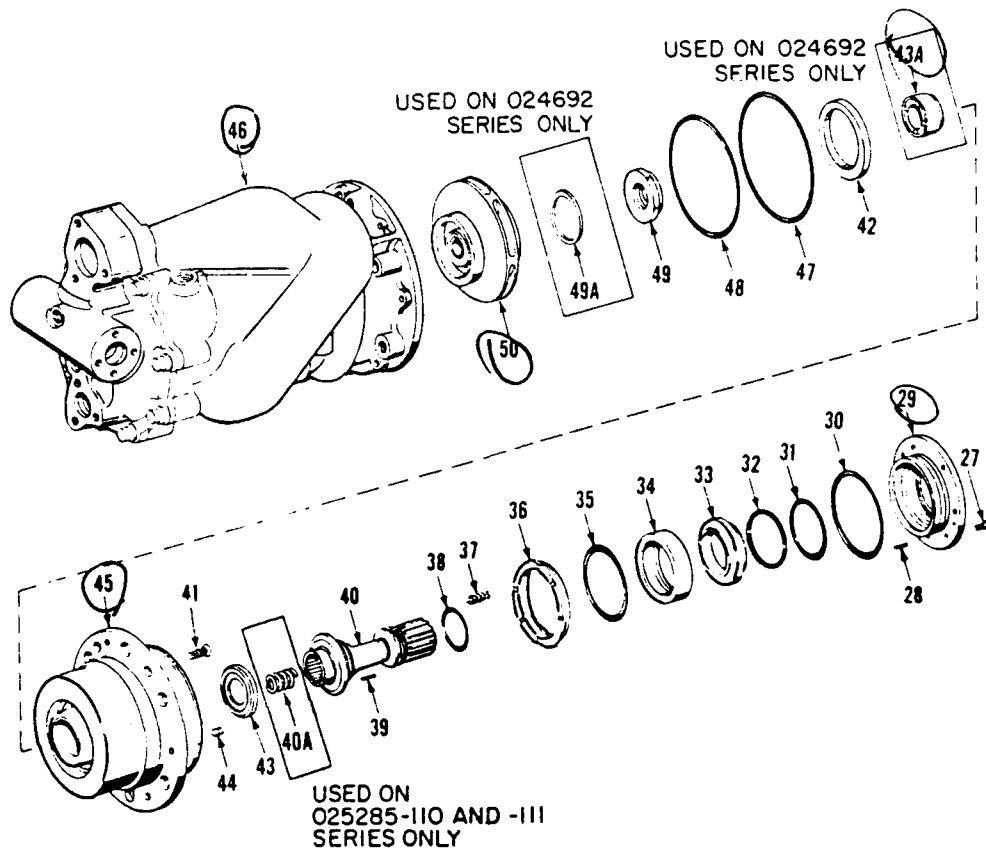
□ INSPECTION

LSC-20147



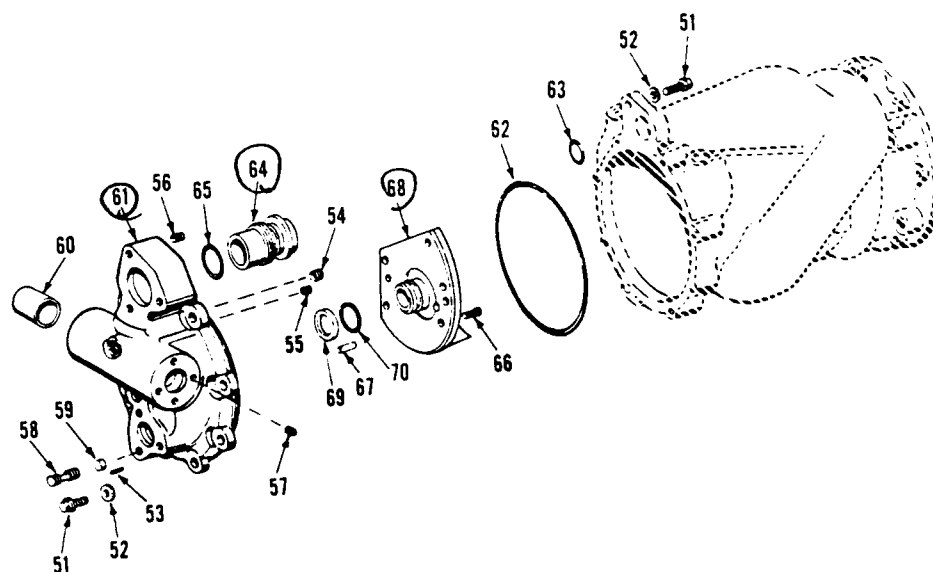
A-43421-1

Figure 1. Exploded View of Axial Piston Pump Assembly (Sheet 1)



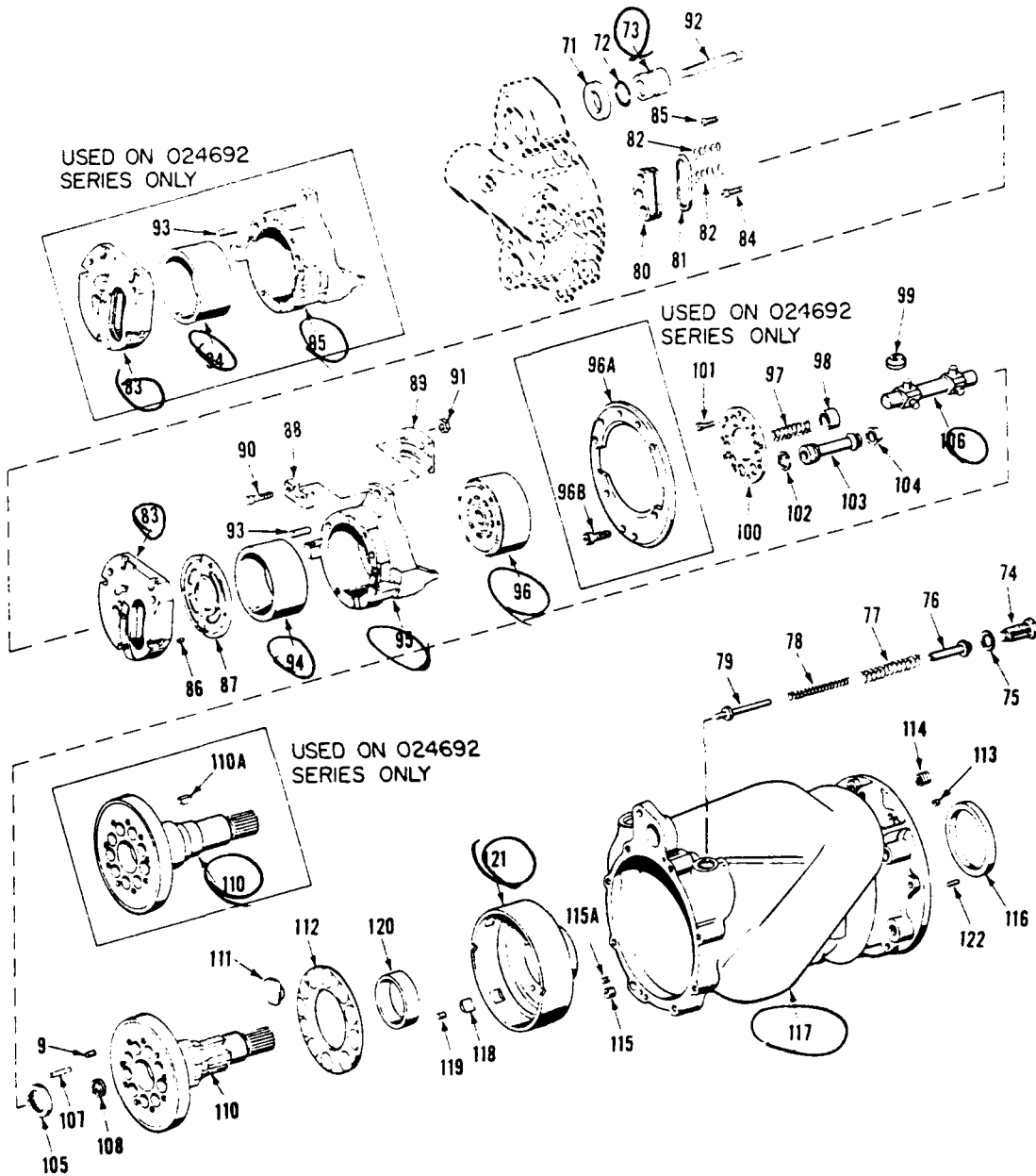
A-19700-1

Figure 1. Exploded View of Axial Piston Pump Assembly (Sheet 2)



A-19701-1

Figure 1. Exploded View of Axial Piston Pump Assembly (Sheet 3)



A-19702

Figure 1. Exploded View of Axial Piston Pump Assembly (Sheet 4)

FIG. & INDEX NO.	PART NO.	DESCRIPTION							UNITS PER ASSY.	USABLE ON CODE
		1	2	3	4	5	6	7		
1/1	025285-107-01	PUMP ASSEMBLY, Axial Piston							1	A
	025285-110-01	PUMP ASSEMBLY, Axial Piston							1	B
	025285-111-01	PUMP ASSEMBLY, Axial Piston							1	C
	024692-114-18	PUMP ASSEMBLY, Axial Piston							1	D
	024692-112-18	PUMP ASSEMBLY, Axial Piston							1	E
	024692-113-18	PUMP ASSEMBLY, Axial Piston							1	F
-1	99-4209	. NUT, Cap plain							1	
-2	02-14569	. PLUG							1	
-3	99-4602-10	. GASKET							1	
-4	02-14575	. SCREW, Adjusting							1	
-5	99-4601-014	. PACKING, Preformed							1	
-6	02-14574	. SEAT, Compensator valve							1	
-7	99-4017-01	. SPRING, Compensator valve							1	
-8	02-15817	. RETAINER, Spring							1	ABCDF
	02-14573-02	. RETAINER, Spring							1	E
-9	02-14590	. PLUG, Adjusting screw							1	
-10	02-14571	. SCREW, Adjusting							1	
-11	99-4601-006	. PACKING, Preformed							1	
-12	AN814-4DL	. PLUG							2	
-13	99-4602-04	. PACKING, Preformed							3	
-14	99-4378	. PLUG, Shipping							1	
-15	99-5000-18	. PLATE, Identification							1	
-16	99-4213-01	. SCREW, Cap, socket head (AP)							4	
-17	02-14570-03	. PLUG, Compensator valve							1	
-18	99-4365-08	. SCREW, Cap, socket head							4	
-19	99-4362	. RETAINER, Packing backup							1	
-20	99-4601-113	. PACKING, Preformed							1	
-21	02-15818	. SPOOL							1	ABCDF
-22	02-14151	. SLEEVE							1	ABCDF
-22A	102-1046	. SPOOL AND SLEEVE ASSEMBLY							1	E
	02-14152	. . SPOOL							1	E
	02-14151	. . SLEEVE							1	E
-23	99-3518-12	. RING, Seal							1	
-24	MS28774-12	. RETAINER							1	
-25	99-2973-11	. RING, Seal							1	
-26	99-2973-10	. RING, Seal							1	
-26A	02-14576-01	. PIN, Straight headless							1	E

FIG. & INDEX NO.	PART NO.	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY.	USABLE ON CODE
1/2	102-1193	. COVER SUBASSEMBLY, Seal	1	
-27	99-4295-03	. SCREW, Cap, socket head (AP)	6	
-28	99-4207-02	. . PIN, Straight headless	1	
(29)	02-14572-02	. . COVER, Seal	1	
-30	99-4601-038	. PACKING, Preformed	1	
-31	99-4991	. RETAINER, Packing, backup	1	
-32	99-4601-223	. PACKING, Preformed	1	
-33	02-14149-02	. RING, Seal	1	
-34	02-14568-03	. RING, Seal rotating	1	
-35	99-3518-228	. RING, Seal	1	
	M83248/2-228	. RING, Seal	1	
	NAS1594-228	. RING, Seal	1	
-36	02-14577-03	. WASHER, Thrust	1	
-37	99-4262	. SPRING, Shaft seal	8	
-38	99-4601-126	. PACKING, Preformed	1	ADEF
	5902378	. PACKING, Preformed	1	BC
	102-1157-02	. COUPLING, Subassembly	1	
-39	99-4420-04	. . PIN, Straight headless	2	
(40)	02-14563-02	. . COUPLING, Shaft, rigid drive	1	
	No Number	. HOUSING AND FRONT COVER SUB- ASSEMBLY (Unmatched)	1	ABC
	102-1161-06	. HOUSING AND FRONT COVER SUB- ASSEMBLY (Matched Set)	1	DEF
	102-1159-03	. . COVER SUBASSEMBLY, Front	1	ABC
	102-1159-01	. . COVER SUBASSEMBLY, Front	1	DEF
-40A	5005226	. SPRING, Helical compression	1	BC
-41	99-4211-01	. . SCREW, Machine, flat head (AP)	2	
-42	02-15452	. . . SLEEVE, Labrynth	1	ABC
	02-14720	. . . SLEEVE, Labrynth	1	DEF
-43	02-14580-03	. . . BUSHING, Sleeve, front cover	1	ABC
	02-14580-02	. . . BUSHING, Sleeve, front cover	1	DEF
(43A)	02-14581-02	. . . BEARING, Sleeve	1	DEF
-44	MS21209C0815	. . . INSERT, Screw, locking	6	
(45)	02-14550-03	. . . COVER, Front	1	ABC
	02-14550-01	. . . COVER, Front	1	DEF
(46)	102-1160-12	. . HOUSING SUBASSEMBLY (see sheet 4 for details)	1	ABC
	102-1160-06	. . HOUSING SUBASSEMBLY (see sheet 4 for details)	1	DEF
-47	99-4601-155	. PACKING, Preformed	1	
-48	99-4601-154	. PACKING, Preformed	1	
-49	99-4912	. NUT, Thin, self-locking	1	ABC
-49A	02-14719	. WASHER, Thrust, impeller	1	DEF
(50)	02-14561-02	. IMPELLER, Pump	1	ABC
	02-14561-01	. IMPELLER, Pump	1	EF
	5000614	. IMPELLER, Pump	1	D
	102-1162-16	. COVER SUBASSEMBLY, Rear	1	

FIG. & INDEX NO.	PART NO.	DESCRIPTION							UNITS PER ASSY.	USABLE ON CODE
		1	2	3	4	5	6	7		
1/3-51	99-4214-08	.	BOLT, 12-Point head (AP)						9	DEF
-52	AN960-516	.	WASHER (AP)						9	
-53	AN385AH3P10	.	PIN, Taper (KD)						1	
-54	MS21209F4-15	.	INSERT, Screw locking,						1	
			helical coil							
-55	MS21209F4-20	.	INSERT, Screw locking,						5	
			helical coil							
-56	MS21209F5-15	.	INSERT, Screw locking,						1	
			helical coil							
-57	MS124753	.	INSERT, Screw locking,						4	
			helical coil (MS21208F1-20)							
-58	99-4205	.	STUD						6	
-59	99-4000-5	.	KEY RING, Key locked						6	
-60	02-14620	.	SLEEVE						1	
-61	02-14543-16	.	COVER, Rear						1	
-62	99-4601-247	.	PACKING, Preformed						1	
-63	99-4601-026	.	PACKING, Preformed						1	
-64	02-14567-04	.	BUSHING, Actuator piston						1	
	02-14567-03	.	BUSHING, Actuator piston						1	
-65	99-2973-21	.	RING, Seal						1	
	102-1192-02	.	GUIDE SUBASSEMBLY, Retainer						1	
			port slipper							
-66	99-4320-03	.	SCREW, Cap, socket head (AP)						5	
-67	99-3985-08	.	PIN, Straight headless						1	
-68	02-14694-02	.	GUIDE, Retainer, port slipper						1	
-69	MS28774-18	.	RETAINER, Packing backup						1	
-70	99-3518-18	.	RING, Seal						1	

FIG. & INDEX NO.	PART NO.	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY.	USABLE ON CODE
1/4-71	99-4149-04	. SEAL, OD Channel	1	
-72	99-2973-113	. RING, Seal	1	
-73	02-14565-01	. PISTON, Actuator	1	
-74	02-14587-03	. SEAT, Ball socket	2	
-75	99-4602-06	. PACKING, Preformed	2	
-76	02-14585-03	. RETAINER, Spring return	2	
-77	99-4018-01	. SPRING, Return	1	
-78	99-4020-01	. SPRING, Return	2	
-79	02-14584-04	. GUIDE, Spring return	2	
-80	02-14699-04	. PORT SLIPPER, Discharge	1	
	02-14699-01	. PORT SLIPPER, Discharge	1	DEF
-81	02-14986	. SEAL, Slipper discharge	1	
-82	99-4903	. SPRING, Port slipper	2	
	99-4260	. SPRING, Port slipper	2	DEF
-83	102-1554	. RETAINER SUBASSEMBLY, Port slipper	1	
	102-1196-07	. RETAINER SUBASSEMBLY, Port slipper	1	DEF
-84	99-4324-07	. SCREW, Cap, socket head (AP)	1	
-85	99-4324-04	. SCREW, Cap, socket head (AP)	4	
-86	99-4399	. . PIN, Shouldered	1	
-87	02-14824-02	. INSERT, Slipper retainer	1	
-88	02-15538-01	. RETAINER, Actuator rod	1	ABCDF
-89	5000610	. PLATE, Retaining	1	AC
-90	NAS1351C06-16	. SCREW, Cap, socket head, self-locking (AP)	2	ABC
-91	5900338	. NUT, Hex, miniature (AP)	2	AC
-92	02-14140	. ROD, Actuator	1	
	5000611	. PIVOT SUBASSEMBLY, Cylinder barrel		
	102-1154-02	. PIVOT SUBASSEMBLY, Cylinder barrel	1	DEF
-93	99-3988-07	. . PIN, Dowel	2	
-94	02-14385	. . BEARING, Pivot	1	
-95	5000611-1	. . PIVOT, Cylinder barrel	1	
	02-14689	. . PIVOT, Cylinder barrel	1	DEF
-96	02-14690-02	. CYLINDER BARREL	1	
-96A	02-14707-02	. STOP, Shaft	1	DEF
-96B	99-4307-03	. SCREW, Cap, socket head (AP)	2	DEF
-97	99-4258	. SPRING, Pivot	1	
-98	02-14586	. SEAT, Ball socket	1	
-99	02-14378-13	. ROLLER, Universal	6	
-100	02-14603-01	. PLATE, Piston return	1	
-101	99-4208-08	. SCREW, Cap, socket head (AP)	7	
	102-1156-05	. PISTON AND RING SUBASSEMBLY	9	
	102-1156-04	. PISTON AND RING SUBASSEMBLY	9	DEF
-102	02-14166-03	. . RING, Piston	1	
	02-14166-02	. . RING, Piston	1	DEF
-103	02-14600-05	. . PISTON, Pump	1	
-104	02-14606-02	. BALL END, Piston	9	

FIG. & INDEX NO.	PART NO.	DESCRIPTION	UNITS PER ASSY.	USABLE ON CODE
174-105	02-15012	. RING, Retaining	1	
-106	02-14554-06	. COUPLING, Shaft, rigid universal	1	
	02-14554-01	. COUPLING, Shaft, rigid universal	1	DEF
-107	02-14987	. INSERT, Wear, drive shaft	3	
-108	02-14578	. SEAT, Ball socket, pivot	1	
	102-1190-06	. SHAFT SUBASSEMBLY, Shouldered	1	ABC
	5000615	. SHAFT SUBASSEMBLY, Shouldered	1	D
	102-1190-07	. SHAFT SUBASSEMBLY, Shouldered	1	EF
-109	02-14683	. . PIN, Shouldered	2	
-110	02-15713	. . SHAFT, Shouldered	1	BC
	102-1194-05	. . SHAFT SUBASSEMBLY, Shouldered	1	DEF
-110A	02-14755-01	. KEY, Woodruff	AR	DEF
	102-1163	. SEAT SUBASSEMBLY, Multiple ball socket	1	
-111	02-14536	. . BEARING, Thrust	12	
-112	02-14552	. . SEAT, Ball socket, multiple	1	
	No Number	. HOUSING AND FRONT COVER SUB- ASSEMBLY (Unmatched)	REF	ABC
	102-1161-06	. HOUSING AND FRONT COVER SUB- ASSEMBLY (Matched set)	REF	DEF
	102-1160-12	. . HOUSING SUBASSEMBLY (See 1-40)	REF	ABC
	102-1160-06	. . HOUSING SUBASSEMBLY (See 1-40)	REF	DEF
-113	02-14579	. . . SEAT, Puller screw	4	
-114	MS21209F6-20	. . . INSERT, Screw locking helical coil	6	
-115	MS21209F5-15	. . . INSERT, Screw locking helical coil	8	
-115A	MS21209F1-20	. . . INSERT, Screw locking helical coil	2	DEF
-116	02-15451	. . . SLEEVE, Labrynth	1	ABC
	02-14721	. . . SLEEVE, Labrynth	1	DEF
-117	02-14556-04	. . . HOUSING, Pump	1	ABC
	02-14556-01	. . . HOUSING, Pump	1	DEF
	102-1151-04	. . . RETAINER SUBASSEMBLY, Bearings and pin	1	
-118	02-14535-03 BEARING, Radial	7	
-119	99-3985-12 PIN, Straight headless	1	
-120	02-14551 BEARING, Sleeve	1	
-121	02-14540-03 RETAINER, Radial and sleeve bearing	1	
-122	99-3985-08	. . PIN, Straight headless	2	
	99-1973	. BLOCK, Shipping	1	
	99-1972	. GASKET	1	
	99-4217	. BLOCK, Shipping	1	
	99-4218	. GASKET	1	
	32-0454	PARTS KIT, Pump, Field (Leakproof)	1	
	99-204-07	. WASHER	6	
	99-112-01	. NUT, Hex	6	
	99-4215	. BLOCK, Shipping	1	
	AN4047-1	. GASKET	1	
	98-312-416-32	. SCREW, Slotted round head	2	

"IN" DATES PROGRAM

NAME <u>ALC OC-ALC</u>		DATE <u>31 MAY 89</u>		NCC <u>MTPCB</u>		SHEET <u>1</u> OF <u>1</u>	
PCH <u>50134A</u>		PATIENT WCD		PATIENT WCD DATE			
OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	HRS Δ TIME (HRS)				
1	8291	8292	24				
2	8295	8298	72				
3	8307	8307	0				
4	8321	8323	48				
5	8344	8344	0				
6	9009	9011	48				
7			(32)				

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING ENGINEERS IN BLOCK 5 OF WCD ON DATE

"OUT" DATES PROFILE

NAME _____		ALC <u>α-ACC</u>		DATE <u>31 MAY 89</u>		NCC <u>WTPCB</u>		SHEET <u>1</u> OF <u>1</u>	
PCI <u>50134A</u>		PATIENT WCD _____		PATIENT WCD DATE _____					
OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	HRS A TIME (MMSS)						
1	8295	8295	0						
2	8300	8302	48						
3	8312	8312	0						
4	8326	8326	0						
5	8347	8348	24						
6	9013	9013	0						
			(12)						

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE NCC.

OPERATION PROFORMA

NAME <u>L. T. P. C. B.</u> ALC <u>OC</u> DATE <u>5/5/89</u> RCC <u>MATPCB</u> SHEET <u>1</u> OF <u>5</u>		WCD <u>CBE402A</u> WCD DATE <u>89019</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
00	MAT	IN	1.0	PROCESS	1.0 30.0							
1	PCB	REC	1.0	PROCESS		AD 09	1	1.0 4.5	BEN 46	1	1.0 4.5	
20		DIS	1.0	PROCESS			1	1.0 8.0	BEN 46	1	1.0 8.0	
30		CLN	1.0	PROCESS			1	1.0 50	OC 3020	1	1.0 50	
31		CLN	1.0	PROCESS			1	1.0 30	OC 4132	1	1.0 30	

OPERATION PROC FILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 2 OF 5				
PCB HSII PIL		WCD CBE402A		WCD DATE 89019		WCD DATE 89019						
50135A												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % INRS.	SKILL CODE/LEVEL	MAINTPOWER QTY.	TIME REQUIRED % INRS.	EQUIPMENT QTY.	EQUIPMENT CODE	TIME REQUIRED % INRS.	DATA SOURCE COMMENTS
34	MAT	PROC	1.0	PROCESS	1.0 2.0	BPO9	1	1.0 2.0	1	0C447	1.0 2.0	Dry end cool
60	PCB	Insp	1.0	PROCESS	1.0 2.0		1	1.0 6.5	1	BEN48	1.0 6.5	
73		INSP	1.0	PROCESS	1.0 2.3		1	1.0 2.3	1	BEN48	1.0 2.3	
83		ASSY	1.0	PROCESS	1.0 4.3		1	1.0 4.3	1	BEN48	1.0 4.3	
100		PROC	1.0	PROCESS	1.0 9.0		1	1.0 9.0	1	3391	1.0 9.0	

OPERATION PROCEDURE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 5

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANIPULATOR		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	QTY.	%	
110	MA T PCB	CLN	1.0	PROCESS	—	—	BP09	1	1.0	1178	1.0	20
111		PROC	1.0	PROCESS	1	1.0		1	1.0	4547	1.0	20
120		INSP	1.0	PROCESS	—	—		1	1.0	BEN 48	1.0	1.6
125		DIS	1.0	PROCESS	—	—		1	1.0	BEN 48	1.0	14.0
133		ASSY	1.0	PROCESS	—	—		1	1.0	BEN 48	1.0	2.4

dry, include cooling

OPERATION PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET <u>5</u> OF <u>5</u>				
PCB		WCD <u>CB EY02 A</u>		WCD DATE _____		WCD DATE _____						
PHI <u>50135A</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % INH.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % INH.	EQUIPMENT CODE	QTY.	TIME REQUIRED % INH.	DATA SOURCE COMMENTS
140	MAT	ASSY	1.0	PROCESS		BPO9	1	1.0 16.0	BEN 48	1	1.0 16.0	
150		TEST	1.0	PROCESS	1.0 48.0							CB backshop
151		CLN	1.0	PROCESS		BPO9	1	1.0 2.25	OC 3020	1	1.0 2.25	
152		CLN	1.0	PROCESS			1	1.0 2.0	OC 4132	1	1.0 2.0	
154		CLN	1.0	PROCESS	1.0 2.0		1	1.0 2.0	OC 4140	1	1.0 2.0	dry & cool

OPERATIONAL PROFILE

NAME _____ ALC _____ DATE _____ RCC _____		SHEET 5 OF 5										
PCN NSN PIN 50135A		WCD CBE402A										
WCD DATE _____		RCC _____										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
157	MAT PCB	CLN	1.0	SETUP	-	AP07	1	1.0 1.4	OC 1174	1	1.0 1.4	
158		INSP	1.0	PROCESS	-	AP07	1	1.0 4.0	BEN48	1	1.0 4.0	
160		ASSY	1.0	PROCESS	-	BP09	1	1.0 12.0	BEN48	1	1.0 12.0	
170		INSP	1.0	PROCESS	-		1	1.0 1.2	BEN48	1	1.0 1.2	
180		PUJ	1.0	PROCESS	-		1	1.0 1.0	BEN48	1	1.0 1.0	
9999		OUT	1.0	PROCESS	-		1	1.0 24.0	BEN48	1	1.0 24.0	

DISASSEMBLY/ASSEMBLY PROFILE

NAME TOTTEN ALC OC DATE 5/1/89 RCC MATRUB SHEET 1 OF 1

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASST. Y/N
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHILD WCD	CHILD WCD DATE	
PCN 50135A/ NSH PIN 50138A	CBE402	89019	040	210	PCN 50135A/ NSH PIN 50138A	5081	89019	N
PCN 49302A, 49806A, 49300A, 49810A	CBE401	89088	080	310	PCN 50135A, NSH PIN 50138A	CBE402	89019	N
PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			
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PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			

LSC-20075A

FLOW PROCESS CHART

SUBJECT J-50, F22 FUEL NOZZLE ASSY - 1000000000

DATE 5/1/89

ITEM CODE

PCN ☒
NSN ☐
P/N ☐

WCD CBE 402

WCD DATE 2907

50135A 50172J

50135A = EXHAUST NOZZLE
50172J = 1000000000

CHART BEGINS 1

CHART ENDS 150

PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
1		●○○□▽	1000000000			●○○□▽	1000000000
5		○●○○□▽	1000000000			●○○□▽	1000000000
3		○●○○□▽	1000000000	125	72	●○○□▽	1000000000
10	10	●○○□▽	1000000000	128	155	○●○○□▽	1000000000
20	20	●○○□▽	1000000000	157		○●○○□▽	1000000000
35		○●○○□▽	1000000000	160	165	●○○□▽	1000000000
30	30	●○○□▽	1000000000	170	170	○●○○□▽	1000000000
31	30	●○○□▽	1000000000	180	180 193	●○○□▽	1000000000
32	30	●○○□▽	1000000000			○●○○□▽	1000000000
33	30	●○○□▽	1000000000			○●○○□▽	1000000000
34	30	●○○□▽	1000000000			○●○○□▽	1000000000
35	30	●○○□▽	1000000000			○●○○□▽	1000000000
60	60	○●○○□▽	1000000000			○●○○□▽	1000000000
70	70	○●○○□▽	1000000000			○●○○□▽	1000000000
75	75	○●○○□▽	1000000000			○●○○□▽	1000000000
80	80	●○○□▽	1000000000			○●○○□▽	1000000000
85		●○○□▽	1000000000			○●○○□▽	1000000000
100	100	●○○□▽	1000000000			○●○○□▽	1000000000
105		●○○□▽	1000000000			○●○○□▽	1000000000
110	110	●○○□▽	1000000000			○●○○□▽	1000000000
111		●○○□▽	1000000000			○●○○□▽	1000000000
112		●○○□▽	1000000000			○●○○□▽	1000000000
120		○●○○□▽	1000000000			○●○○□▽	1000000000
125		●○○□▽	1000000000			○●○○□▽	1000000000
130	130	●○○□▽	1000000000			○●○○□▽	1000000000
135	135	●○○□▽	1000000000			○●○○□▽	1000000000
140	140	●○○□▽	1000000000			○●○○□▽	1000000000
150	150	●○○□▽	1000000000			○●○○□▽	1000000000
151		●○○□▽	1000000000			○●○○□▽	1000000000
152		●○○□▽	1000000000			○●○○□▽	1000000000
153		●○○□▽	1000000000			○●○○□▽	1000000000
154		●○○□▽	1000000000			○●○○□▽	1000000000

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

Δ DELAY

LSC-20147

OPERATION PROFILE

NAME <u>E. Totten</u> ALG <u>OC</u> DATE <u>5/5/89</u> RCC <u>MATPCB</u> SHEET <u>1</u> OF <u>2</u>														
PCB <u>50135A</u> WCD <u>CBENT2A</u> WCD DATE <u>88174</u>														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
20	MAT PCB	IN	1.0	PROCESS	1.0 24.0									
5		REC	1.0	PROCESS		OP09	1	1.0	1.0	0702	1	1.0	1.0	
8		PROC	.40	PROCESS			1	1.0	.50	0702	1	1.0	.50	
10		PROC	1.0	PROCESS			1	1.0	.50	0702	1	1.0	.50	
20		TEST	1.0	PROCESS			1	1.0	3.5	0702	1	1.0	3.5	

OPERATION PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 3 OF 2	
WCD 50135A		WCD CBEA72A		WCD DATE _____		RCC _____		SHEET 3 OF 2	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	MANPOWER	EQUIPMENT	DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.
51	MAT PCB	DIS	1.0	TRANSIT	—	DP07	1	1.0	1.0
				SETUP	—				
				PROCESS	—				
52		REP	1.0	TRANSIT	—		1	1.0	1.0
				SETUP	—				
				PROCESS	—				
53		ASSY	1.0	TRANSIT	—		1	1.0	1.0
				SETUP	—				
				PROCESS	—				
54		PROC	1.0	TRANSIT	—		1	1.0	1.0
				SETUP	—				
				PROCESS	—				
60		PW	1.0	TRANSIT	—		1	1.0	1.0
				SETUP	—				
				PROCESS	—				
9999		QAT	1.0	Process	1.0				30.0

"IN" DATES PROFILE

NAME _____		ALC <u>OC-ALC</u>		DATE <u>31 MAY 89</u>		RCC <u>MTPCB</u>		SHEET <u>1</u> OF <u>1</u>	
PCH ISH PHI		50135A		PARENT WCD		PARENT WCD DATE			
OBSERVATION NUMBER	"II" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (HRS)						
1	8321	8323	48						
2	8328	8330	48						
3	8341	8341	0						
4	8362	8364	48						
			(75)						

LSC-20107A

NOTE: "II" DATE IS THE DATE THAT SCHEDULING EMPLOYERS III BLOCK 5 OF WCD ON DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

[illegible]

"DUE-OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE ICC.

LSU-20103A

ONE ~~WCD~~ WCD 24 MAR 21

OPERATION PROFILE

SOURCE: SHIRLEY SMITH

NAME E. TOTTEN ALC OC DATE 5/3/89 RCC MATPCB SHEET 1 OF 2

ITEM CODE 50136A WCD CBE403 WCD DATE 88-07

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
							QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %	
00	MAT PCB	1 st DATE	1.0	TRANSIT							
010		REC	1.0	SETUP	36	BPO9	02	50	1	50	25% of NOZZLES coming in are from supply - these go to JECG 3123 for unloading. UNLOAD NOZZLES FOR TIME'S SHIP ON 2000 QTY. JECG 3123.
020		MOVES IN	1.0	TRANSIT	0.1	BPO5	001	100	1	100	MOVE NOZZLES ON TRAILER FROM DUG 3123 TO SHIP IN 3001.
030		UNLO	1.0	SETUP	0.2	BPO9	001	100			SECOND TRAILER. MOVE NOZZLES TO MANIFOLD DISASSEMBLY AREA AND STACK.
040		REC	1.0	TRANSIT	0.1	BPO9	001	100	1	100	INCLUDE NOZZLES FROM TORN SUPPLY AND MANIFOLD W/SHIRLEY. FROM TIME THAT OF NOZZLES FROM MANIFOLD ASSET AREA TO SHIP SHIP. TIME'S SHIP.

(FROM MANIFOLD) IN 512 R

OPERATION PROFILE ORIGINAL

NAME <u>E. TOTTEN</u>		ALC _____		DATE _____		RCC _____		SHEET <u>3</u> OF <u>8</u>												
ITEM CODE <u>50136A</u>		WCD <u>CBE-103</u>		WCD DATE _____																
OPERATION NUMBER	ROC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS								
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED %	TIME REQUIRED HRS.						
100	MAT PCB	CLN	1.0	TRANSIT	.75	BP09	001	100	0.1				AIR DRY WITH HOT AIR DRYER TANK.							
				SETUP																
				PROCESS																
110		REL	1.0	TRANSIT	1.0			100	1.0				ALCOA HOT NOZZLES TO AIR TOOL FOR 1 HR.							
				SETUP																
				PROCESS																
120		PROC	1.0	TRANSIT	0.3	BP09	001	100	0.1	BULK6	1	50	0.1	SMOBLAST NOZZLE AFTER CLEANING AND DRYING.						
				SETUP																
				PROCESS																
130		INSP	1.0	TRANSIT	0.1	BP09	001	100	0.1	BULK6	1	100	0.1	MICROGRATER INSPECTION 2 MIN/MOZZLE (AFTER: MENTHA CHECK, PHASE FILE 2.5 MIN/MOZZLE)						
				SETUP																
				PROCESS																
140		PROC	1.0	TRANSIT	<0.1	BP09	001	100	0.1	BULK6	1	100	0.1	2.5 MIN TO REMOVE OLD OFFICER, REPLACE MEDLINE.						
				SETUP																
				PROCESS																

TIME
CANNOT
BE
DETERMINED
FOR
LARGE

OPERATION PROFILE

ORIGINAL

NAME L. T. TOTTEN ALC DATE 1968 WCD CBF 403 SHEET 4 OF 8

ITEM CODE	OPERATION NUMBER	ROC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
								QTY.	%	HRS.	QTY.	%	HRS.	
150		MAT PCB	PROC.	1.0	TRANSIT	0.1	BPO9	1	100	0.1	BELH6	1	100	0.1
					SETUP									
					PROCESS									
160			PROC	1.0	TRANSIT	0.1	BPO9	1	100	0.1	BELH6	1	100	0.1
					SETUP									
					PROCESS									
170			CLN	1.0	TRANSIT	0.3	BPO9	1	100	0.3	OC1178	1	100	0.2
					SETUP						OC4947	1	100	0.1
					PROCESS									
180			PROC	1.0	TRANSIT	0.2	BPO9	1	100	0.2	BELH6	1	100	0.2
					SETUP									
					PROCESS									
190			CLN	1.0	TRANSIT	0.3	BPO9	1	100	0.3	OC1178	1	100	0.2
					SETUP						OC4947	1	100	0.1
					PROCESS									

NOTE: SECTIONS: ORLAK, ARAY FOR PENETRATION OF 10.0 OIL. TOTAL TIME 0.3 MIN.

PLATE NO. 2222 NOT IN "ECO CATION" BOX FOR LAPPING. MACHINE LAP. AFTER NOT SURFACE. AFTER PARALLEL TIME PER NOT TO LAP 3-4 MIN.

CLEAN LAPED NOT IN PD680. DETACHER SOLUTION. BOX NOT AFTER DETACHING.

LAPPING OF BUSINESS 10-15 MIN. DETACHING NOT LAPED IN BOX. QUANTITIES OF 2. QUANTITIES MAY BE 2 LAPS (1/2 OF TIME).

CLEAN BUSHING IN PD680 TANK. THIS MEASUREMENT 0.5 MIN. THEN PLACE IN TANK.

WIPING BUSHING 2/1 METER ARRANGE SIMILAR DETACH

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/3/89 RCC MAT PCB SHEET 5 OF 8

PCN 5036 A WCD CDC 403 WCD DATE 8/8/79

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED %	TIME REQUIRED HRS.
200	MAT PCB	1 NSP	1.0	TRANSIT		8P09	1	100	0.1	BUN 49	1	100	0.1	INSTANT BUSHING AND MOUNTING W/ MICROFILM AFTER LAPPING. 1 MIN PER MOUNTING AVG.
				SETUP										
				PROCESS										
210		1 NSP	1.0	TRANSIT		8P09	1	100	0.1	BUN 49	1	100	0.1	INSTANT BUSHING MOUNTING SETS 1 MIN. PER UNIT
				SETUP										
				PROCESS										
220		1 NSP	1.0	TRANSIT		8P09	1	100	0.1	N/A	1	100	0.1	INSTANT BUSHING. TAPPING AFTER LAPPING. 1 MIN PER UNIT (VISUAL INSPECTION)
				SETUP										
				PROCESS										
230		1 NSP	1.0	TRANSIT		8P09	1	100	0.1	BUN 49	1	100	0.1	
				SETUP										
				PROCESS										
240		ASSY	1.0	TRANSIT		8P09	1	100	0.1					2-3 MIN PER UNIT. DO 48 BUSHING TAPPING. STEP 1.5-1.8 HZ TOTAL BUSHING TO 1.5 MIN. (VISUAL)
				SETUP										
				PROCESS										

OPERATION PROFILE

ORIGINAL

SHEET 6 OF 8

DATE 5/3/69

ALC OC

WCD 58136A

WCD 58174

RCC MAT PCB

PCN

ITEM CODE 58136A

WCD 58174

WCD 58174

WCD 58174

WCD 58174

WCD 58174

WCD 58174

WCD 58174

WCD 58174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
								%	HRS.	%	HRS.	
250	MAT PCB	PROC	1.0	TRANSIT		BPO9	1	100	0.1	100	0.1	TO BE USED FOR TESTING TO 300 IN/LS. 21 MIN PER ADDRESS
260		PROC	1.0	TRANSIT		BPO9	1	100	0.1	100	0.1	TO BE USED FOR TESTING TO 300 IN/LS. 21 MIN PER ADDRESS
270		PROC	1.0	TRANSIT		BPO9	1	100	0.1	100	0.1	TO BE USED FOR TESTING TO 300 IN/LS. 21 MIN PER ADDRESS
280		MOVE	1.0	TRANSIT		BPO9	1	100	0.2	100	0.2	TO BE USED FOR TESTING TO 300 IN/LS. 21 MIN PER ADDRESS
290		TEST	1.0	TRANSIT		BPO9	1	100	0.2	100	0.2	TO BE USED FOR TESTING TO 300 IN/LS. 21 MIN PER ADDRESS

B/S

TIME
HOURS
MINUTES
OF TEST
FIGURES

OPERATION PROFILE

ORIGINAL

NAME <u>C. TORREN</u>		ALC <u>OC</u>		DATE _____		RCC _____		SHEET <u>7</u> OF <u>8</u>										
ITEM CODE <u>50136A</u>		WCD <u>3E403</u>		WCD DATE <u>8/17/74</u>														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS						
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED %	TIME REQUIRED HRS.				
300	MAF PB	MOVE	1.0	TRANSIT		BP09	1	100	0.2				SOME STICK NOT BE PLACED AT END OF SMIT. TIME NORMALLY .8 HR.					
				SETUP														
				PROCESS														
310		TEST	1.0	TRANSIT		BP09	1	100	0.1	OC 0952	1	100	0.1	PERFORM LEAK TEST w/ M2 1 MIN PER MORRIS. HAS POSS LONG UNLOAD W2 MIN/MORRIS				
				SETUP														
				PROCESS														
320		ASSY	1.0	TRANSIT		BP09	1	100	0.1	BEN49	1	100	0.1	APPROX 2-2.5 MIN. PER MORRIS, 1 BOX OF 48 DONE IN 1-1.5 HR.				
				SETUP														
				PROCESS														
330		INSP	1.0	TRANSIT		BP09	1	100	0.1				USUALLY MORRIS. WAS ALSO CALLED FOR FINAL RE-SAMPLE. THAT IS NOT DONE. MORRIS ARE PLACED IN BOXES FOR MOVEMENT TO TRAINING ASSY.					
				SETUP														
				PROCESS														
340		PW		TRANSIT		BP09	1	100	0.1				COMPLY w/ MAFI CC-18 & 18 IF MORRIS GO TO SUPPLY MORE PAPERWORK IS REQUIRED					
				SETUP														
				PROCESS														

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/2/89 RCC MAT PCB SHEET 8 OF 8

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
							QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.			
350	MAT PCB	PW	1.0	TRANSIT	0.1	809	1	100	0.1				SIGNATURE
360	V	PW	1.0	TRANSIT	0.1	809	1	100	0.1				ATTO 549
9999		OUT DATE	1.0	TRANSIT	24								READY FOR SETC
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

PCN
P/N

WCD DATE 88174

WCD CBE403

SUBJECT 50136 A FLOW PROCESS CHART DATE 6-13-89

ITEM CODE
PCN
NSN
PIN

WCD CB8403

WCD DATE 88174

50136 A

CHART BEGINS 10

CHART ENDS 360

PREPARED BY P. Hunt

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
10	10	●○○□▽	RIC	320	320	●○○□▽	PCW
20	20	○●○○□▽	MOVE	330	330	○○○■▽	INSP.
30	30	●○○□▽	UNLOAD	340	340	●○○□▽	CLW MTR.
40	40	●○○□▽	RECEIVE	350	350	●○○□▽	PCW
50	50	●○○□▽	DIS	360	360	●○○□▽	CLW MTR.
60	60	●○○□▽	CLEAN			○○○□▽	
70	70	●○○□▽	CLEAN			○○○□▽	
80	80	●○○□▽	CLEAN			○○○□▽	
90	90	●○○□▽	CLEAN			○○○□▽	
100	100	●○○□▽	CLEAN			○○○□▽	
110	110	●○○□▽	DRZ			○○○□▽	
120	120	●○○□▽	SANDBLAST			○○○□▽	
130	130	○○○■▽	INSP. MICR			○○○□▽	
140	140	●○○□▽	PROC.			○○○□▽	
150	150	○○○□▽				○○○□▽	
160	160	●○○□▽	INSTALL ORH			○○○□▽	
170	170	●○○□▽	LAP NOZZLE			○○○□▽	
180	180	●○○□▽	CLEAN			○○○□▽	
190	190	●○○□▽	LAP			○○○□▽	
200	200	○○○■▽	MICROMETER			○○○□▽	
210	210	○○○■▽	VISUAL INSP.			○○○□▽	
220	220	○○○■▽	VISUAL INSP.			○○○□▽	
230	230	○○○■▽	INSP.			○○○□▽	
240	240	●○○□▽	ASSY, TORQUE			○○○□▽	
250	250	●○○□▽	TORQUE			○○○□▽	
260	260	●○○□▽	TORQUE			○○○□▽	
270	270	●○○□▽	PAPERWORK			○○○□▽	
280	280	○○○□▽	CARRY INTEST			○○○□▽	
290	290	○○○■▽	TST IN 3108			○○○□▽	
300	300	○○○□▽	ONTO CONVEYOR			○○○□▽	
310	310	○○○■▽	LEAK TEST			○○○□▽	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

□ DELAY

LSC-20147

SECTION VII

ILLUSTRATED PARTS BREAKDOWN

7-1. GENERAL. This section lists and describes the parts for the fuel nozzle (Figure 7-1) installed on J57 Engines manufactured by United Technologies Corporation, Pratt & Whitney Aircraft Group, Government Products Division, P. O. Box 2691, West Palm Beach, Florida 33402, U.S.A.

7-2. MAINTENANCE PARTS LIST. The Maintenance Parts List consists of the complete fuel nozzle, as shown in figure 7-1. The assembly listed has its component parts indented thereunder, to show their relationship to the assembly. Interchangeable and substitute assemblies and parts, subsequently authorized by the Government, are not listed in this manual; such items are identified by information available through the Interchangeable and Substitute (I&S) Data Systems, refer to T.O. 00-25-184.

7-3. UNITS PER ASSEMBLY. The quantities listed in the Units per Assy. column of the Maintenance Parts List are, in the case of assemblies, the total quantity used per fuel nozzle at the location indicated, while the component parts indented under the assemblies are the quantity used per assembly. The quantities specified, therefore, are not necessarily the total used per fuel nozzle.

7-4. PART NUMBERS. Part numbers are used exclusively to identify parts.

7-5. INDEX NUMBERS. The index numbers appearing on the illustration are numerically arranged by figure numbers in the Maintenance Parts List and are used mainly to assist in locating a part in the Maintenance Parts List after it has been found on an illustration. The illustration in this section is intended primarily to facilitate the identification of parts. This section is intended as a supplement to, not a substitute for, the associated maintenance and overhaul sections which shall be considered the final authority on assembly procedures.

7-6. SUPERSEDES. Supersedes indicates that the old and new parts are interchangeable. The disposition of parts subject to the term Supersedes as identified in this section shall further be governed by any applicable specific instructions, such as Time Compliance Technical Orders.

7-7. DIMENSIONS. All dimensions shown herein are nominal. They are inserted to facilitate identification for ordering, and are not to be construed as restrictive in inspection.

7-8. SOURCE, MAINTENANCE, AND RECOVERABILITY (SMR) CODES. Definitions of applicable source, maintenance, and recoverability (SMR) codes are set forth in T.O. 00-25-195.

7-9. ABBREVIATIONS. The abbreviations used throughout this section are as follows:

Abbreviation	Full Name
ASSY	Assembly
DIA	Diameter
C/O	Consists of
ID	Inside Diameter
IN	Inch(es)
MTR	Metering
NO.	Number(s)
NOZ	Nozzle
OD	Outside Diameter
OPTL	Optional
OVHL	Overhaul
PRCMT	Procurement
PRI	Primary
RTNG	Retaining
SEC	Secondary
SPR	Spring
THK	Thick

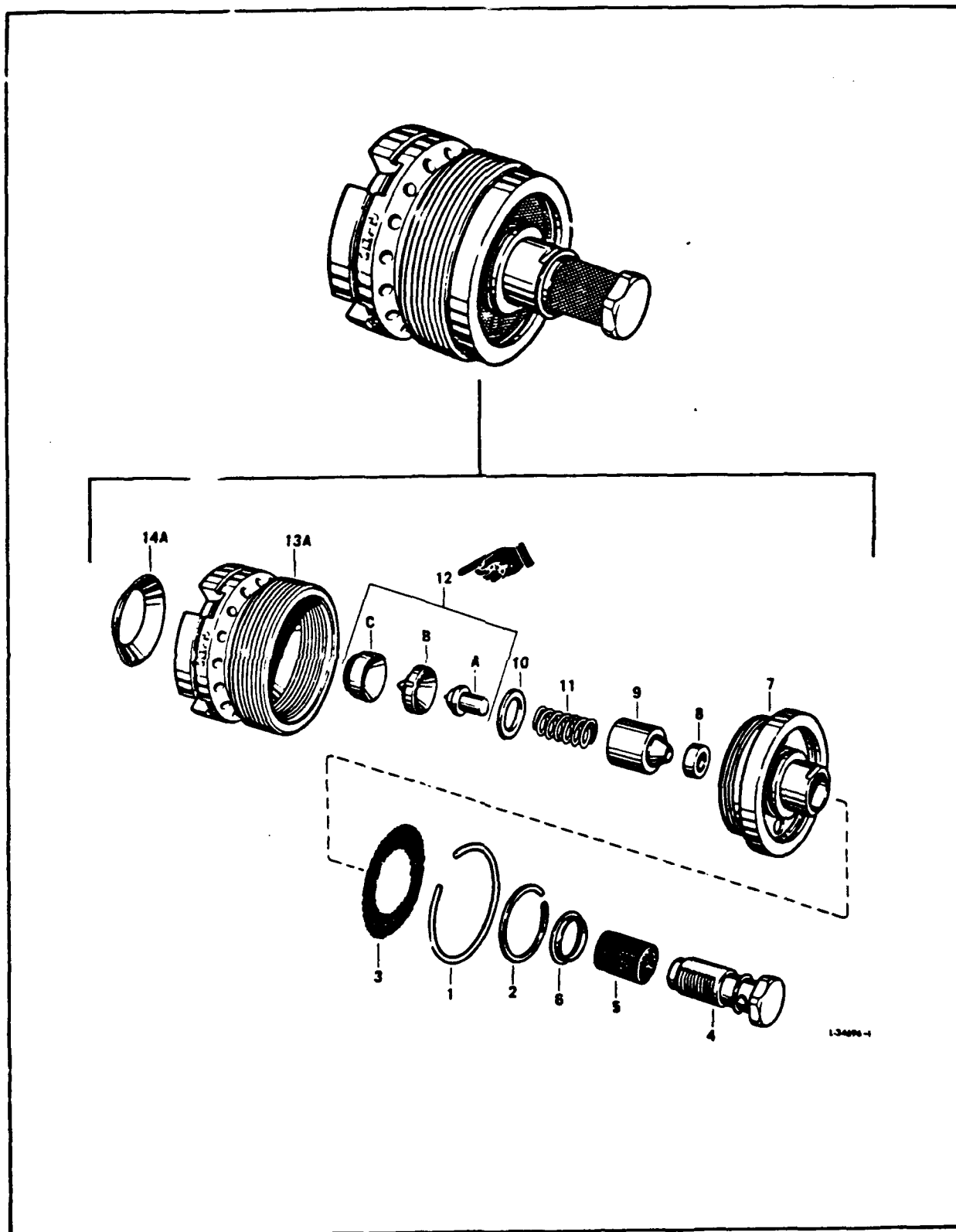


Figure 7-1. Fuel Nozzle

FIGURE & INDEX NUMBER	PART NUMBER	1234567 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
7-1	3 18466	FUEL NOZZLE NOZZLE ASSEMBLY-FUEL, 492 102 repair kit AVAILABLE	24		
-1	267286	.RING-Rtng-0.8 10 OD x 0.035 in. thk	1		PADZZ
-2	267285	.RING-Rtng-0.404 ID x 0.035 in. thk	1		PADZZ
-3	267440	.STRAINER OPTION-Fuel noz sec prcmt no. c/o	1		PADZZ
	267443	STRAINER-optl to 267444			P 1
	267444	STRAINER-optl to 267443			P 1
-4	267281	.HOUSING-Fuel noz pri strainer	1		PADZZ
-5	267439	.STRAINER OPTION-Fuel noz pri prcmt no. c/o	1		PADZZ
	267441	STRAINER-optl to 267442			P 1
	267442	STRAINER-optl to 267441			P 1
-6	267283	.FLANGE-Fuel noz strainer	1		PADZZ
-7	267277	.BUSHING-Fuel noz	1		
-8	267287	.SEAL-Fuel noz spr seat	1		PADZZ
-9	267282	.SEAT-Fuel noz spr	1		PADZZ
-10	267288	.GASKET-0.2255 ID x 0.3 105 OD x 0.031 in. thk, fuel noz spr	1		PADZZ
-11	267284	.SPRING-0.190 OD x 0.029 in. dia wire, fuel noz	1		PADZZ
-12	267279	.NOZZLE-Fuel mtr set	1		
-13	DELETED				
-13A	3 18467	.NUT-Fuel noz rtng	1		
-14	DELETED				
-14A	3 18468	.DEFLECTOR-Fuel noz air	1		PADZZ
	492 102	KIT-Repair, for repair of 3 18466 noz assy	1		D

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 06-13-89 RCC MATPCB SHEET 1 OF 5

PCN 50136A WCD CB5473 WCL DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	%	HRS.	
00	MATP CB	IN DATE	1.0	TRANSIT									
				SETUP									
				PROCESS									
05	MATP CB	ABOVE	1.0	TRANSIT			1	100					48 PER BATCH. TIMES SHOW ARE PER EXH.
				SETUP									
				PROCESS									
10	MATP CB	TEST	1.0	TRANSIT									0C702, 0C703, 0C705 ARE ALTERNATES.
				SETUP									
				PROCESS			1	100		0C701	1	100	0C705 ARE ALTERNATES.
15	MATP CB	TEST	1.0	TRANSIT									REMOVE MASTER NO 2200
				SETUP									
				PROCESS			1	100		0C701	1	100	0C705 ARE ALTERNATES.
20	MATP CB	TEST	1.0	TRANSIT									85% ARE GOOD AND REQUIRE ONLY 5 MIN.
				SETUP									
				PROCESS			1	100		0C701	1	100	0C705 ARE ALTERNATES.

OPERATION PROFILE

NAME <u>P. Hunt</u>		ALC <u>OC</u>		DATE <u>6-13-89</u>		RCC <u>MATPCB</u>		SHEET <u>2</u> OF <u>3</u>					
WCD <u>CB54T3</u>		WCD <u>50136A</u>		VCD DATE									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
					%	HRS.	QTY.	%	QTY.	CODE			%
25	MATP CB	TEST	.15	TRANSIT								15% MISC BAD, AND REQUIRES REWORK	
				SETUP									
				PROCESS									
30	MATP CB	TEST	1.0	TRANSIT								Hours Included in # 20, THIS IS INFO. ONLY CAPABILITY.	
				SETUP									
				PROCESS									
40	MATP CB	TEST	1.0	TRANSIT								SPRAY COME ANGLE. Hours Included in # 20 ABOVE.	
				SETUP									
				PROCESS									
50	MATP CB	PW	1.0	TRANSIT								PW, COMIN FOR ACC 48 IN BATCH.	
				SETUP									
				PROCESS									
60	MATP CB	PW	1.0	TRANSIT								CW MAO-1 66-36 Page 13	
				SETUP									
				PROCESS									

OPERATION PROFILE

NAME PHUNT ALC OC DATE 6-13-89 RCC MAP PCB SHEET 3 OF 3

PCN 50136A WCD CB5473 VCD DATE _____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	QTY.	EQUIPMENT CODE	%	HRS.	
70.	MAP CB	move	1.0	TRANSIT									RET TO FINAL ASY,
				SETUP									
				PROCESS									
9999	MAP CB	OUT DATE	1.0	TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

FLOW PROCESS CHART

SUBJECT _____ **DATE** _____

ITEM CODE

WCD CBE4T3 WCD DATE 88174

ACK
NON
PUN

50136A

CHART BEGINS

CHART ENDS

PREPARED BY E. TOTTEN

[illegible]

OPERATION

TRANSPORTATION

▽ STORAGE

D DELAY

☐ INSPECTION

LSC-20147

"IN" DATES PROFILE

NAME <u>ALC DC-ALC</u>		DATE <u>31 MAY 99</u>	RCC <u>MTPCB</u>	SHEET <u>1</u> OF <u>1</u>
PCN INSH PHI	<u>50136 A</u>	PARENT WCD	PARENT WCD DATE	
OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	HRS Δ TIME (BASE)	
1	8312	8315	72	
2	8327	8327	0.	
3	8348	8349	24	
4	8356	8358	48	
			36	

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING EDITORS IN BLOCK 5 OF WCD ON DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

[illegible]

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE ICC.

LS-C-2010:8A

OPERATION PRO E

NAME <u>E. Teten</u> ALC <u>OC</u> DATE <u>5/5/69</u> RCC <u>MAT PCB</u> SHEET <u>1</u> OF <u>5</u>		WCD <u>CBE402B</u> WCD DATE <u>89019</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INHOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	PROCESS	1.0 30.0									
1		REC	1.0	PROCESS		AP 09	1	1.0	4.5	BEN 46	1	1.0	4.5	
20		DIS	1.0	PROCESS			1	1.0	8.0	BEN 48	1	1.0	8.0	
30		CLN	1.0	PROCESS			1	1.0	5.0	OC 3020	1	1.0	5.0	
31		CLN	1.0	PROCESS			1	1.0	3.0	OC 4132	1	1.0	3.0	

OPERATION PRO E

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 2 OF 5					
PCII		WCD CBE402B		WCD DATE 89019									
PHI		50138A											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAIPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	INS.	QTY.	%	INS.	QTY.		%	INS.
34	MAT	PROC	1.0	PROCESS	1.0	2.0	1	1.0	2.0	1	1.0	2.0	dry and cool
60		Insp	1.0	PROCESS	1	6.5	1	1.0	6.5	1	1.0	6.5	
73		INSP	1.0	PROCESS	1	2.3	1	1.0	2.3	1	1.0	2.3	
83		ASSY	1.0	PROCESS	1	4.3	1	1.0	4.3	1	1.0	4.3	
100		PROC	1.0	PROCESS	1	9.0	1	1.0	9.0	1	1.0	9.0	

OPERATION PROC. LE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 3 OF 5				
PCN 30138A		WCD CBE4028		WCD DATE _____		WCD DATE _____						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	MAINTENANCE QTY.	TIME REQUIRED % HRS.	EQUIPMENT QTY.	EQUIPMENT CODE	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
110	MAT	CLN	1.0	TRANSFER	-							
	PCB			SETUP	-							
				PROCESS	-	BPO9	1	1.0	1.0	1178	1.0	20
111		PROC	1.0	TRANSFER	-							001, including cooling
				PROCESS	1		1	1.0	1.0	4947	1.0	20
120		INSP	1.0	TRANSFER	-							
				SETUP	-							
				PROCESS	-		1	1.0	1.6	BEN48	1.0	1.6
125		DIS	1.0	TRANSFER	-							
				SETUP	-							
				PROCESS	-		1	1.0	14.0	BEN48	1.0	14.0
133		ASSY	1.0	TRANSFER	-							
				SETUP	-							
				PROCESS	-		1	1.0	2.4	BEN48	1.0	2.4

OPERATION PROCEDURE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET <u>2</u> OF <u>5</u>				
PCH _____		HSH _____		PHI _____		WCD <u>CB EY02 B</u>		WCD DATE _____				
50138A		MAT		RCC		OPERATION DESCRIPTION		MANDATORY OCCURRENCE FACTOR				
OPERATION NUMBER	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
140	TRANSF											
	SETUP											
	PROCESS											
	TRANSF											
	SETUP											
	PROCESS											
150	TRANSF											
	SETUP											
	PROCESS											
	TRANSF											
	SETUP											
	PROCESS											
151	TRANSF											
	SETUP											
	PROCESS											
	TRANSF											
	SETUP											
	PROCESS											
152	TRANSF											
	SETUP											
	PROCESS											
	TRANSF											
	SETUP											
	PROCESS											
154	TRANSF											
	SETUP											
	PROCESS											

CB backshop

Dry & cool

OPERATIONAL PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET <u>5</u> OF <u>5</u>									
PCN _____		NSN <u>50138A</u>		WCD <u>CBE 402 B</u>		VICD DATE _____											
PIN _____																	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			TIME REQUIRED %	HRS.	DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%				HRS.
157	MAT PCB	CLN	1.0	PROCESS	-	-	AP07	1	1.0	1.4	OC 1174	1	1.0	1.4			
158		INSP	1.0	PROCESS	-	-	AP07	1	1.0	4.0	BEN 48	1	1.0	4.0			
160		ASSY	1.0	PROCESS	-	-	BP09	1	1.0	12.0	BEN 48	1	1.0	12.0			
170		INSP	1.0	PROCESS	-	-											
180		PW	1.0	PROCESS	-	-					BEN 48	1	1.0	1.2			
9999		OUT	1.0	PROCESS	-	-		1	1.0	.50	BEN 48	1	1.0	.50			
				PROCESS	1.0	24.0											

FLOW PROCESS CHART

SUBJECT J-51, TF33 FUEL NOZZLE ASSY DISASSEMBLY

DATE 5/5/89

ITEM CODE

PCN ☒
NSN ☐
P/N ☐

WCD CLE 402

WCD DATE 29019

50135A, 50138A

50135A = EXCELLO NOZZLE
50138A = PG NOZZLE

CHART BEGINS 1

CHART ENDS 180

PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
1		●○○○▽	REMOVE GASKET FROM NOZZLES/NUTS	151		●○○○▽	HOT AIR WAX NUTS
5		○●○○▽	REMOVE NOZZLES FROM TRAY	152		●○○○▽	CIR COOL NUTS
3		○●○○▽	REMOVE NUTS FROM TRAY	153	152	●○○○▽	REMOVE NUTS
10	10	●○○○▽	MOVE AND INSPECT NUTS (45 TRAY) ETC.	154	155	○●○○▽	USUALLY INSPECT NUTS THREADS
20	20	●○○○▽	DISASSEMBLE	157		○●○○▽	SOFT PENA SPRING NUTS
25		○●○○▽	IN 100% TEST	160	160	●○○○▽	FINAL ASSEMBLY NOZZLES NUTS
30	30	●○○○▽	CLEAN EXHAUST MANIFOLD	170	170	○●○○▽	INSPECT NOZZLE FUNCTION
31	30	●○○○▽	SWAP NUTS	180	180 170	●○○○▽	FINAL PAPEWORK
32	30	●○○○▽	CLEAN NUTS SEAL			○●○○▽	
33	30	●○○○▽	WATER RINSE			○●○○▽	
34	30	●○○○▽	CLEAN EXHAUST			○●○○▽	
35	30	●○○○▽	AIR COOL			○●○○▽	
60	60	○●○○▽	INSPECT, POLISH			○●○○▽	
70	70	○●○○▽	INSPECT EXHAUST MANIFOLD JOINT			○●○○▽	
75	75	○●○○▽	INSPECT NOZZLE NUT FLANGE			○●○○▽	
80	80	●○○○▽	ASST. INSTALL NUTTING SET ETC.			○●○○▽	
85		●○○○▽	ASST. REMOVE NUTS NUTTING SET ETC.			○●○○▽	
100	100	●○○○▽	INSTALL, LAP NOZZLES			○●○○▽	
105		●○○○▽	REMOVE NOZZLES FROM TRAY, TRAY NOZZLES			○●○○▽	
110	110	●○○○▽	CLEAN NOZZLES IN SU 100%			○●○○▽	
111		●○○○▽	NUT - VARIOUS REQUIREMENTS			○●○○▽	
112		●○○○▽	AIR COOL			○●○○▽	
120		○●○○▽	REMOVE NOZZLING FROM TRAY AND INSPECT			○●○○▽	
125		●○○○▽	DISASSEMBLE ONLY REMOVE NUTS FROM RING			○●○○▽	
130	130	●○○○▽	INSPECT AND MEASURE RING (50138 ONLY)			○●○○▽	
135	135	●○○○▽	ASST. REMOVE NUTTING SET ETC.			○●○○▽	
140	140	●○○○▽	ASST. REMOVE NUTS FROM TRAY AND INSPECT			○●○○▽	
150	150	●○○○▽	MOVE TO TRAY TEST RING AND BACK-UP			○●○○▽	
151		●○○○▽	CLEAN NUTS - ACID			○●○○▽	
152		●○○○▽	WATER RINSE NUTS			○●○○▽	
153		●○○○▽	CLEAN NUTS - ACID			○●○○▽	
154		●○○○▽	WATER RINSE NUTS			○●○○▽	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

D DELAY

LSC-20147

VARIOUS REQUIREMENTS - EXCHANGING ETC.

NUT
DISASSEMBLY/ASSEMBLY

B/S
NUT
ASSEMBLY/ASSEMBLY

OPERATION PROFILE

NAME <u>E. Totten</u> ALC <u>OC</u> DATE <u>5/5/89</u> RCC <u>MATPCB</u> SHEET <u>1</u> OF <u>2</u>		WCD <u>CBEAT2B</u> WCD DATE <u>88174</u>													
PCN	ISSN	PRN	50138A												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
20	MAT PCB	IN	1.0	PROCESS	1.0	2400									
5		REC	1.0	PROCESS											
8		PROC	.40	PROCESS											
10		PROC	1.0	PROCESS											
20		TEST	1.0	PROCESS											

OPERATION PROFIL

NAME _____		ALC _____		DATE _____		RCC _____		SHEET 3 OF 2		
WCD 40135A		WCD CB E4728		WCD DATE		WCD DATE				
STATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INQUIRY	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	
51	MAT	DIS	1.75	TRANSIT	---	---	---	---	---	---
	PcB			SETUP	---	---	---	---	---	---
				PROCESS	---	---	DP07	1	1.0	1.45
				TRANSIT	---	---	---	---	---	---
				SETUP	---	---	---	---	---	---
52		REP	1.0	PROCESS	---	---	---	1	1.0	1.0
				TRANSIT	---	---	---	---	---	---
				SETUP	---	---	---	---	---	---
53		ASSY	1.0	PROCESS	---	---	---	1	1.0	1.0
				TRANSIT	---	---	---	---	---	---
				SETUP	---	---	---	---	---	---
54		PROC	1.0	PROCESS	---	---	---	1	1.0	1.0
				TRANSIT	---	---	---	---	---	---
				SETUP	---	---	---	---	---	---
				PROCESS	---	---	---	1	1.0	1.48
60		PW	1.0	TRANSIT	---	---	---	---	---	---
				SETUP	---	---	---	---	---	---
				PROCESS	---	---	---	1	1.0	1.14
9999		QYT	1.0	PROCESS	1.0	300	---	---	---	---

DATE 5/5/89

WCD DATE 88174

50135A 50138A

CHART ENDS

PREPARED BY *E. TOTTEN*

☐ INSPECTION

D DELAY

② REPAIR STEPS PERFORMED IF TEST(S) FAIL(S). REPEAT CYCLE UNTIL PASS.

LSC-20147

SHEET 1 OF 1

[illegible]

NOTE: "11" DATE IS THE DATE THAT SCHEDULING ITEMS IN BLOCK 5 OF WCD ON DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

LSC-20107A

[illegible]

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENTS FROM THE ICC.

LSJ-20108A

OPERATION PROFILE

NAME <u>PHUNT</u> ALC <u>OC</u> DATE <u>53089</u> RCC <u>MPCB</u> SHEET <u>1</u> OF <u>3</u>		PCN <u>96515A</u> WCD <u>CBE706</u> WCD DATE <u>88267</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
							QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.	
00	MAP CB	IN DATE	1.0	TRANSIT										
				SETUP										
				PROCESS	24									
10	MAP CB	REC	1.0	TRANSIT										NO MATRUC
				SETUP										
				PROCESS			1	100	.42	BEN436	1	100	.42	
15	MAP CB	CLN	1.0	TRANSIT										PD680 AIR DRY
				SETUP										OC417B
				PROCESS			1	100	.17	OC4447	1	100	.08	PLI
20	MAP CB	DIS	1.0	TRANSIT										
				SETUP										
				PROCESS			1	100	1.0	BEN436	1	100	1.0	
30	MAP CB	CLN	1.0	TRANSIT										WIPE PARTS CLEAN AS REQ'D.
				SETUP										
				PROCESS			1	100	.10	BEN436	1	100	.10	

NAME <u>PHUAT</u>		ALC <u>OC</u>		DATE <u>53089</u>		RCC <u>MTPCB</u>		SHEET <u>2 OF 3</u>								
PCN <u>96513A</u>		WCD <u>CBEYOG</u>		WCD DATE <u>88267</u>												
OPERATION NUMBER		RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS			
						%	INS.	SKILL CODE/ LEVEL	QTY.	%	INS.	EQUIPMENT CODE	QTY.	%	INS.	
40	MTPB CB	INSPECTION	1.0	TRANSIT				AP 09	1	100	1.5	BEN4%	1	100	1.5	INSPECTION
				SETUP												
				PROCESS												
50	MTPB CB	NDI	1.0	TRANSIT				AP 09	1	100	1.5	BEN4%	1	100	1.5	INSPECTION
				SETUP												
				PROCESS												
100	MTPB CB	ASSY	1.0	TRANSIT		100	24	AP 09	1	100	.08	26025	1	100	.08	INSPECTION
				SETUP												
				PROCESS												
110	MTPB CB	TEST	1.0	TRANSIT				AP 09	1	100	1.0	BEN4%	1	100	1.0	INSPECTION
				SETUP												
				PROCESS												
140	MTPB CB	ASSY	1.0	TRANSIT				AP 09	1	100	.33	BEN4%	1	100	.33	INSPECTION
				SETUP												
				PROCESS												

OPERATION PROFILE

NAME <u>PHUA</u>		ALC <u>OC</u>		DATE <u>53089</u>		RCC <u>MTPCB</u>		SHEET <u>3</u> OF <u>3</u>						
PCN <u>96515 A</u>		WCD <u>CBEY06</u>		WCD DATE <u>88267</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	QTY.	%	HRS.	
150	MATP CB	ASSY	1.0	TRANSIT										INST. SHAFT ASSY
				SETUP										
				PROCESS										
160	MATP CB	ASSY	1.0	TRANSIT										INST. IMPELLOR INDUCER
				SETUP										
				PROCESS										
9994	MATP CB	OUT DARE	1.0	TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

FLOW PROCESS CHART
SUBJECT CENTRIFUGAL Pump ASSY

DATE 53089

PCN
NCH.
P/M

WCD DATE 88 26 7

CHART ENDS 250 COMPL AT TO 349

PREPARED BY

○ OPERATION
◇ TRANSPORTATION

▽ STORAGE
D DELAY

☐ INSPECTION

LSC-20147

DISASSEMBLY/ASSEMBLY PROFILE

NAME PHOT

ALC OC

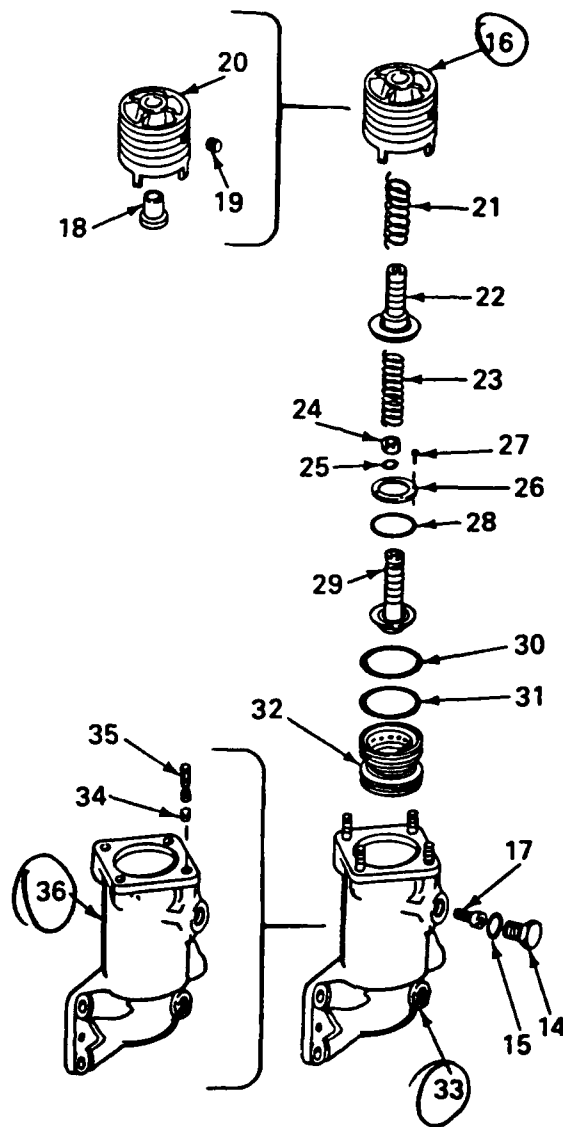
DATE 53089

RCC MTPECB

SHEET 1 OF 1

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED W/O ASST. YIN
ITEM NUMBER	WCO	WCO DATE			ITEM NUMBER	CHILD WCO	CHILD WCO DATE	
PCN NSH PIN 96515A	CB0706	88267	20	200	PCN NSH PIN 02-14731	CB070651		N
PCN NSH PIN					PCN NSH PIN 102-1231-01	CB070652		N
PCN NSH PIN					PCN NSH PIN 102-1235-02	CB070653		N
PCN NSH PIN					PCN NSH PIN 02-14868-2	CB070654		
PCN NSH PIN					PCN NSH PIN 102-1302-02	CB070655		
PCN NSH PIN					PCN NSH PIN 102-1347-04	CB070656		
PCN NSH PIN					PCN NSH PIN 102-1142	CB070657		
PCN NSH PIN					PCN NSH PIN 02-14518	CB070658		
PCN NSH PIN					PCN NSH PIN 102-1274-02	CB070659		
PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			
PCN NSH PIN					PCN NSH PIN			

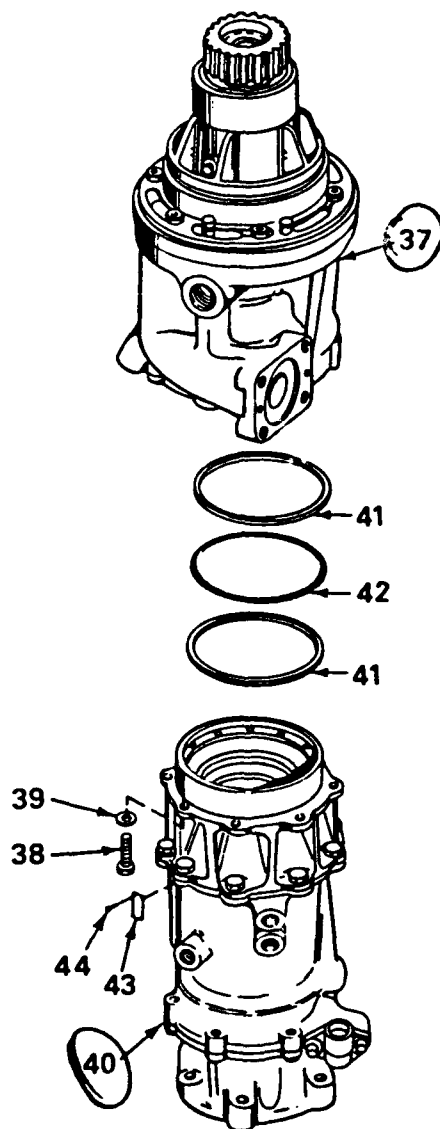
LSC-20075A



A-52046

Figure 1. Centrifugal Pump Assembly (Sheet 2 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMk
1/1-	024536-209-09	99167		PUMP ASSEMBLY, Centrifugal . (Repair Kit Available)	REF	A	PAOLD
	025264-200-02	99167		PUMP ASSEMBLY, Centrifugal .	REF	B	PAOLD
	024536-213-09	99167		PUMP ASSEMBLY, Centrifugal .	REF	C	PAOLD
	024536-214-10	99167		PUMP ASSEMBLY, Centrifugal .	REF	D	PAOLD
-1	02-14887	99167		. FILTER, Oil	1		PAOZZ
-2	99-2975-8	99167		. PACKING, Preformed	1		PAOZZ
-3	102-1381	99167		. VALVE ASSEMBLY, Poppet . . (see figure 2)	1	A	PAOZZ
	102-1381-01	99167		. VALVE ASSEMBLY, Poppet . . (see figure 2)	1	BCD	PAOZZ
-4	99-2975-5	99167		. PACKING, Preformed	1	A	PADZZ
	99-4602-05	99167		. PACKING, Preformed	1	BCD	PADZZ
-5	102-1478	99167		. FILTER ASSEMBLY (see . . . figure 3)	1	B	PADZZ
-6	99-4602-05	99167		. PACKING, Preformed	1	B	PAOZZ
-7	02-14731	99167		. TUBE, Turbine inlet	1		PADZZ
-8	99-4346-112	99167		. PACKING, Preformed	2	A	PADZZ
	99-4601-112	99167		. PACKING, Preformed	2	BCD	PADZZ
-9	99-4498	99167		. RETAINER	2		PADZZ
-10	99-4195-06	99167		. SCREW, Cap (AP)	4		PADZZ
-11	99-4344	99167		. WASHER (AP)	4		PADZZ
-12	99-4346-221	99167		. PACKING, Preformed	1	A	PADZZ
	99-4601-221	99167		. PACKING, Preformed	1	BCD	PADZZ
-13	99-4345	99167		. CAP SEAL	1		PADZZ

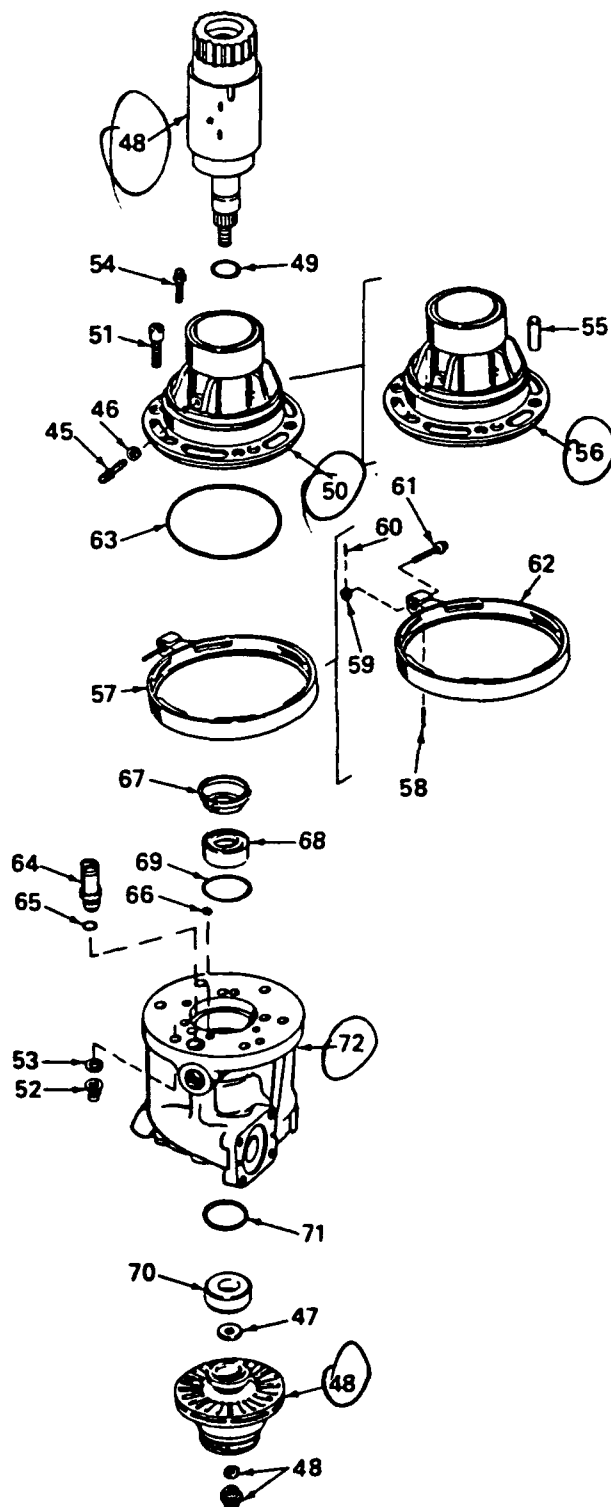


A-52651

Figure 1. Centrifugal Pump Assembly (Sheet 3 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
1/2-							
-14	AN814-4L	88044	.	PLUG	1		PADZZ
-15	99-2975-4	99167	.	PACKING, Preformed	1	A	PAOZZ
	99-4602-04	99167	.	PACKING, Preformed	1	BCD	PAOZZ
(16)	102-1231-01	99167	.	GUIDE SUBASSEMBLY, Flow . .	1		PADZZ
-17	99-4196-02	99167	.	SCREW, Socket head (AP) . .	1		PADZZ
-18	02-14781	99167	.	GUIDE, Valve	1		PADZZ
-19	MS21209F4-15	96906	.	INSERT	1		PADZZ
-20	02-14801-01	99167	.	GUIDE, Flow	1		PADZZ
-21	99-4303	99167	.	SPRING, High pressure check valve	1		PADZZ
-22	02-14875-02	99167	.	VALVE, High pressure check	1		PADZZ
-23	99-4304	99167	.	SPRING, Low pressure check valve	1		PADZZ
-24	99-4302	99167	.	RING, Glyd	1		PADZZ
-25	99-2973-6	99167	.	PACKING, Preformed	1		PADZZ
-26	02-15301	99167	.	RETAINER, Packing	1	ACD	PADZZ
	02-15301-01	99167	.	RETAINER, Packing	1	B	PADZZ
-27	99-4581	99167	.	SCREW, Flat head (AP) . . .	6		PADZZ
-28	99-4580	99167	.	PACKING, Preformed	1		PADZZ
-29	02-15302	99167	.	VALVE, Low pressure check .	1		PADZZ
-30	99-2973-127	99167	.	PACKING, Preformed	1		PADZZ
-31	99-2973-127	99167	.	PACKING, Preformed	1	A	PADZZ
	99-4601-127	99167	.	PACKING, Preformed	1	BCD	PADZZ
-32	02-15397	99167	.	SEAT, Check valve	1		PADZZ
(33)	102-1235-02	99167	.	VALVE HOUSING SUBASSEMBLY, Check	1		PADZZ
-34	KR5A-15	99057	.	RING, Key	4		PADZZ
-35	99-4186	99167	.	STUD	4		PADZZ
(36)	02-14808-02	99167	.	HOUSING, Valve	1		PADLD

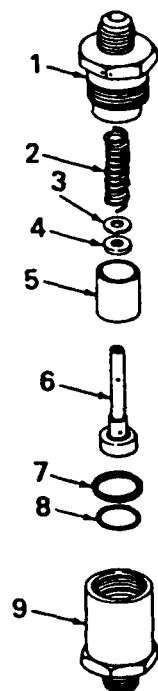
Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
1/3- 37 38 39 40	No Number	99167	.	PUMP UNIT ASSEMBLY	1		PADBZ
	99-4190	99167	.	BOLT (AP)	8		PADZZ
	AN960-516L	88044	.	WASHER (AP)	8		PADZZ
	102-1302-02	99167	.	INLET VALVE & INDUCER	1	A	PADZZ
				SUBASSEMBLY (see figure 4)			
	102-1561-03	99167	.	INLET VALVE & INDUCER	1	B	PADZZ
				SUBASSEMBLY (see figure 4)			
	102-1302-05	99167	.	INLET VALVE & INDUCER	1	C	PADZZ
				SUBASSEMBLY (see figure 4)			
	102-1302-06	99167	.	INLET VALVE & INDUCER	1	D	PADZZ
				SUBASSEMBLY (see figure 4)			
-41	99-4496	99167	.	RETAINER, Packing	2		PADZZ
-42	99-4346-241	99167	.	PACKING, Preformed	1	A	PADZZ
	99-4601-241	99167	.	PACKING, Preformed	1	BCD	PADZZ
-43	99-5000-03	99167	.	PLATE, Identification	1		PADZZ
-44	AN535-00-2	88044	.	SCREW (AP)	4		PADZZ



A-52650

Figure 1. Centrifugal Pump Assembly (Sheet 4 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
1/4-							
-45	99-4188	99167	.	BOLT	3		PADZZ
-46	MS20002C4	96906	.	WASHER	1		PADZZ
-47	02-12869-07	99167	.	SHIM (0.001 inch thick) . .	AR	ACD	PADZZ
	02-12869-06	99167	.	SHIM (0.016 inch thick) . .	AR	ACD	PADZZ
	02-12869-05	99167	.	SHIM (0.014 inch thick) . .	AR	ACD	PADZZ
	02-12869-04	99167	.	SHIM (0.012 inch thick) . .	AR	ACD	PADZZ
	02-12869-03	99167	.	SHIM (0.010 inch thick) . .	AR	ACD	PADZZ
	02-12869-02	99167	.	SHIM (0.005 inch thick) . .	AR	ACD	PADZZ
	02-12869-01	99167	.	SHIM (0.003 inch thick) . .	AR	ACD	PADZZ
	02-15827-01	99167	.	SHIM (0.001 inch thick) . .	AR	B	PADZZ
	02-15827-02	99167	.	SHIM (0.003 inch thick) . .	AR	B	PADZZ
	02-15827-03	99167	.	SHIM (0.005 inch thick) . .	AR	B	PADZZ
	02-15827-04	99167	.	SHIM (0.010 inch thick) . .	AR	B	PADZZ
	02-15827-05	99167	.	SHIM (0.012 inch thick) . .	AR	B	PADZZ
	02-15827-06	99167	.	SHIM (0.014 inch thick) . .	AR	B	PADZZ
	02-15827-07	99167	.	SHIM (0.016 inch thick) . .	AR	B	PADZZ
(48)	102-1347-04	99167	.	SHAFT ASSEMBLY, Balancing . (see figure 5)	1	ACD	PADZZ
	102-1522-01	99167	.	SHAFT ASSEMBLY, Balancing . (see figure 5)	1	B	PADZZ
(49)	99-2973-19	99167	.	RING, Seal	1		PADZZ
(50)	102-1142	99167	.	HOUSING SUBASSEMBLY, . . . Bearing	1		PAFDD
-51	99-4368	99167	.	SCREW (AP)	6		PADZZ
-52	LH3830-064	72962	.	NUT (99-4198) (AP)	6		PADZZ
-53	AN960-616L	88044	.	WASHER (AP)	6		PADZZ
-54	99-4194-10	99167	.	BOLT (AP)	3		PADZZ
-55	99-4247	99167	.	. PIN, Dowel	1		PADZZ
(56)	02-14518	99167	.	. HOUSING, Bearing	1		PADBZ
-57	504245	77445	.	NUT, Gearbox, quick disconnect	1	A	PADZZ
	02-16113	77445	.	NUT, Gearbox, quick disconnect (702805)	1	BCD	PADZZ
-58	AN150237	88044	.	. PIN	2		PAFZZ
-59	504243	77445	.	. COLLAR	1		PAFZZ
-60	AN150212	88044	.	. PIN	1		PAFZZ
-61	702086	77445	.	. BOLT	1		PAFZZ
-62	No Number	77445	.	. NUT, Gearbox quick disconnect	1		XA
-63	99-2973-241	99167	.	RING, Seal	1		PADZZ
-64	02-14533	99167	.	SLEEVE, Oil lube	1		PADZZ
-65	99-2973-13	99167	.	RING, Seal	1		PADZZ
-66	99-2973-10	99167	.	RING, Seal	1		PADZZ
-67	02-14859	99167	.	RETAINER	1		PADZZ
-68	02-14696	99167	.	SEAL, Shaft, oil	1		PADZZ
-69	99-2973-130	99167	.	RING, Seal	1		PADZZ
-70	02-14892-01	99167	.	SEAL, Shaft, fuel	1		PADZZ
-71	99-4448	99167	.	PACKING, Preformed	1	A	PADZZ
	99-4601-501	99167	.	PACKING, Preformed	1	BCD	PADZZ
(72)	102-1274-02	99167	.	HOUSING SUBASSEMBLY, Pump . (see figure 6)	1		PADBZ



A-51567

Figure 2. Poppet Valve Assembly

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
2-	102-1381	99167		VALVE ASSEMBLY, Poppet (see index 3, figure 1)	REF	A	PAOZZ
	102-1381-01	99167		VALVE ASSEMBLY, Poppet (see index 3, figure 1)	REF	BCD	PAOZZ
-1	02-15245	99167		. CAP, Valve	1		PAOZZ
-2	99-4531	99167		. SPRING	1		PAOZZ
-3	02-15246-04	99167		. SPACER (0.005 in. thick) .	AR		PAOZZ
	02-15246-03	99167		. SPACER (0.010 in. thick) .	AR		PAOZZ
	02-15246-02	99167		. SPACER (0.015 in. thick) .	AR		PAOZZ
-4	02-15246-01	99167		. SPACER (0.050 in. thick) .	1		PAOZZ
-5	102-1380	99167		. POPPET ASSEMBLY	1		PAOZZ
-6	02-15243	99167		. SEAT, Valve	1		PAOZZ
-7	99-4533	99167		. RETAINER	1		PAOZZ
-8	99-4346-16	99167		. PACKING, Preformed	1	A	PAOZZ
	99-4601-016	99167		. PACKING, Preformed	1	BCD	PAOZZ
-9	02-15242	99167		. HOUSING, Valve	1		PAOZZ
<u>Usable on Code</u>							
A 024536-209-09							
B 025264-200-02							
C 024536-213-09							
D 024536-214-10							

OPERATION OFFICE

NAME PHUNT ALC OC DATE 53089 RCC MPCB SHEET 1 OF 4

PCN 96515A WCD CBET07 WCD DATE 58267

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS				
					%	HRS.			%	HRS.			%	HRS.					
00	MAPP CB	IN DATE	1.0	TRANSIT															
				SETUP															
				PROCESS															
05	MAPP CB	MOV	1.0	TRANSIT												RETRIEVE PUMP CONNECTION LINE - INCREASING			
				SETUP															
				PROCESS				DP 09	1	100	.17								
10	MAPP CB	TEST	1.0	TRANSIT												PREPARE PUMP, MOUNT (MNT) IT LIND			
				SETUP				DP 09	1	100	.17	005139	1	100	.17	TEST STAND 000445 MNT			
				PROCESS															
15	MAPP CB	TEST	1.0	TRANSIT												PUMP, BEARING LUBE 000445 MNT			
				SETUP															
				PROCESS															
20	MAPP CB	TEST	1.0	TRANSIT												PREPARE PUMP 000445 MNT			
				SETUP															
				PROCESS				DP 09	1	100	.02	005139	1	100	.02				
				TRANSIT															
				SETUP															
				PROCESS															

OPERATION PROFILE

NAME <u>PHUNT</u>		ALC <u>DC</u>		DATE <u>53089</u>		RCC <u>117P013</u>		SHEET <u>2</u> OF <u>4</u>				
RCN <u>96515A</u>		WCD <u>CB8707</u>		WCD DATE <u>88239</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED % HRS.
30	MATP CB	TEST	1.0	TRANSIT								CYCLING TEST NO 04/15 AET
				SETUP								
				PROCESS								
40	MATP CB	TEST	1.0	TRANSIT								MIN FLOW CALIB NO 04/15 AET
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

OPERATION PROFILE

NAME PHANT ALC OC DATE 53089 RCC MTPCB SHEET 3 OF 4

PCN 96515A
 INSH
 PTH

WCD CBE 10.7 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MAINTENANCE			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
50	MAPP CB	TEST	1.0	TRANSIT							SCROLL DRAIN VALVE OPERATION OR 000945
				SETUP							
				PROCESS		DP 09	100	005139	1	100	
60	MAPP CB	TEST	1.0	TRANSIT							PUPPET SEAL OR 000945
				SETUP							
				PROCESS		DP 09	100	005139	1	100	
70	MAPP CB	TEST	1.0	TRANSIT							OR 000945
				SETUP							
				PROCESS		DP 09	100	005139	1	100	
130	MAPP CB	TEST	1.0	TRANSIT							REMOVEMENT PLANT TEST STAND, OR 000945
				SETUP							
				PROCESS		DP 09	100	005139	1	100	
140	MAPP CB	TEST	1.0	TRANSIT							OR 000945
				SETUP							
				PROCESS		DP 09	100	005139	1	100	

OPERATION PROFILE

NAME P. HUNT ALC OC DATE 53089 RCC MTPCB SHEET 4 OF 4

BCH
HSH
PHI

WCD 96515A WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAIN POWER			EQUIPMENT			DATA SOURCE COMMENTS		
					%	INS.	SKILL CODE/LEVEL	QTY.	%	INS.	EQUIPMENT CODE	QTY.		%	INS.
180	MATP CB	MOV	1.0	TRANSIT										MOVE TO FINAL ASSY	
				SETUP											
				PROCESS											
190	MATP CB	PW	1.0	TRANSIT										C/W M-102 66-36 FINE	
				SETUP											
				PROCESS											
9999	MATP CB	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

"IN" DATES PRC "LE

NAME _____		ALC <u>ALC</u>	DATE <u>31 MAR 89</u>	RCC <u>MPCB</u>	SHEET <u>1</u> OF <u>1</u>
PCI	ISH	PH	PARENT WCD DATE _____		
96515A		PARENT WCD _____			
OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (HRS)		
1	8272	8273	24		
2	8272	8274	48		
3	8280	8288	0		
4	8335	8336	24		
5	8363	8363	0		
6	9004	9006	48		
			(24)		

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD ON DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

LSC-20107A

"OUT" DATES PRG. ILE

NAME _____		ALC <u>OC-ALC</u>		DATE <u>31 MAY 89</u>	RCC <u>N-PCB</u>	SHEET <u>1</u> OF <u>1</u>
PCN <u>96515A</u>	PATIENT WCD _____	PARENT WCD DATE _____				
OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	"OUT" DATE + TIME (DATE)			
1	8280	8280	0			
2	8280	8280	0			
3	8298	8299	24			
4	8342	8342	0			
5	9005	9005	0			
6	9006	9009	72			
			(16)			

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATION PROFILE

NAME <u>Parker</u>		ALC <u>DC</u>	DATE <u>5/29/88</u>	RCC <u>MAT RB</u>	SHEET <u>1</u> OF <u>6</u>									
PCH <u>96523A</u>		WCD <u>CAEY 08</u>		WCD DATE <u>88235</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
000	MAT	INSP	1.0	PROCESS	24	AP 09	1	1.0	1.0	BEN419	1	1.0	1.0	
010	RB	REC	1.0	PROCESS										
015		INSP	1.0	PROCESS			1	1.0	2.5	BEN419	1	1.0	2.5	external Safely, easily, etc. % Time held regulation, clean checked
020		DIS	1.0	PROCESS			1	1.0	1.0	BEN419	1	1.0	1.0	
030		CLN	1.0	PROCESS										AD 68 - ANK, 100% then degreased with 100% possible disposal
040		INSP	1.0	PROCESS			1	1.0	3.3	BEN419	1	1.0	3.3	

OPERATIC PROFILE

NAME <u>Lacker</u>		ALC <u>DC</u>		DATE <u>5/30/83</u>		RCC <u>MATP B</u>		SHEET <u>2</u> OF <u>6</u>						
PCN <u>96523A</u>		WCD <u>CAEY08</u>		WCD DATE <u>08239</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % INRS.	MANPOWER		EQUIPMENT		TIME REQUIRED % INRS.	DATA SOURCE COMMENTS			
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED % INRS.	EQUIPMENT CODE			QTY.		
045	MAT RB	INSP	1.0	PROCESS	-	BT 09	1	1.0	2.0	0229	1	10	2.0	Flourescent insolvent sp.
047		INSP	1.0	PROCESS	-	(1	1.0	2.0	0625	1	1.0	2.0	Magnetic particle insp. included with above flow hours. m.c. coating, boiler gauges, spray booth charter, etc.
050		INSP	1.0	PROCESS	-	AP 09	1	1.0	5.0	064419	1	1.0	5.0	
060		INSP	1.0	PROCESS	-		1	1.0	0.8	064419	1	1.0	0.8	
060		INSP	1.0	PROCESS	-		1	1.0	0.8	064419	1	1.0	0.8	
060		INSP	1.0	PROCESS	-		1	1.0	0.8	064419	1	1.0	0.8	

OPERATIC PROFILE

NAME <u>Parker</u>		ALC <u>OC</u>		DATE <u>5/30/89</u>		RCC <u>MAT PCB</u>		SHEET <u>4</u> OF <u>6</u>				
PCN <u>96523A</u>		WCD <u>CAEY08</u>		WCD DATE <u>88239</u>								
OPERATION HOLDER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT QTY.	EQUIPMENT CODE	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
125	MAT PCB	REP	1.0	PROCESS	-	AP09	1	1.0 1.50	1	BEN49	1.0 1.5	
140		INSP	1.0	PROCESS	-		1	1.0 2.25	1	BEN49	1.0 2.25	
150		ASSY	1.0	PROCESS	-		1	1.0 2.08	1	BEN49	1.0 2.08	
160		ASSY	1.0	PROCESS	-		1	1.0 2.08	1	BEN49	1.0 2.08	
170		ASSY	1.0	PROCESS	-		1	1.0 2.08	1	BEN49	1.0 2.08	

OPERATIC PROFILE

NAME Perker

ALC

OC

DATE

5/20/84

RCC

MAT PCB

SHEET 5 OF 6

PCB
ISH
PIH

36523A

WCD CAEY08

WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					%	INS.		QTY.	%	TIME REQUIRED	QTY.		%	TIME REQUIRED
180	MAT PCB	ASSY	1.0	PROCESS	-	-	AP09	1	1.0	08	1	1.0	08	
190		ASSY	1.0	PROCESS	-	-		1	1.0	08	1	1.0	08	
210		ASSY	1.0	PROCESS	-	-		1	1.0	08	1	1.0	08	
220		ASSY	1.0	PROCESS	-	-		1	1.0	08	1	1.0	08	
250	MAT PCB	TEST	1.0	PROCESS	1.0	16.0		1	1.0	08	1	1.0	08	Functional test of pump in performed by personnel photo (see Opn Prod

Functional test of pump in bld. 3108. Performed by the personnel located. (see Opn Profile of ACN 96523)

FLOW PROCESS CHART

SUBJECT

MAIN FUEL PUMP

DATE 5/30/89

ITEM CODE

WCD CBEY09

WCD DATE 88239

PCN
NEN
PM□
□
□

96523A

CHART BEGINS

010

CHART ENDS

299

PREPARED BY

E. TOTTEN

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○	REC			○	
015	-	○	INSP			○	
020	020	○	OIS			○	
030	030	○	CLN			○	
040	040	○	INSP			○	
045	-	○	INSP			○	
047	-	○	INSP			○	
050	050	○	INSP			○	
060	060	○	INSP			○	
070	070	○	INSP			○	
073	-	○	REPAIR			○	
075	-	○	CLN			○	
090	090	○	TEST			○	
100	100	○	INSP			○	
120	120	○	INSP			○	
125	-	○	REPAIR			○	
140	140	○	INSP			○	
150	150	○	ASSY			○	
160	160	○	ASSY			○	
170	170	○	ASSY			○	
180	180	○	ASSY			○	
190	190	○	ASSY			○	
210	210	○	ASSY			○	
220	220	○	ASSY			○	
250	250	○	TEST			○	
265	-	○	ASSY			○	
280	280	○	ASSY			○	
299	-	○	PW			○	
		○				○	
		○				○	
		○				○	
		○				○	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

D DELAY

LSC-20147

OPERATION PROFILE

NAME Lacker

ALC OC

DATE 5/20/89

ICC MAT PCB

SHEET 1 OF 3

PCB
HIGH
PRI

96523

WCD CBEY9

WCD DATE 88239

OPERATION NUMBER	ICC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT CODE	QTY.	TIME REQUIRED		EQUIPMENT	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		%	HRS.			%	HRS.			%	HRS.	
000		IN DATE	1.0	TRANSIT														
				SETUP														
				PROCESS		24												
010	MAT PCB	TEST	1.0	TRANSIT														
				SETUP														
				PROCESS			CP09	1.0	1.0	OC	1	1.0	1.0	OC	1	1.0	1.0	
035		TEST	1.0	TRANSIT														
				SETUP														
				PROCESS				1.0	1.5	OC	1	1.0	1.5	OC	1	1.0	1.5	Filter changes, etc.
050		DIS	1.0	TRANSIT														
				SETUP														
				PROCESS				1.0	1.0	OC	1	1.0	1.0	OC	1	1.0	1.0	Dependent on problems requiring retest value adjustments.
060		TEST	1.0	TRANSIT														
				SETUP														
				PROCESS				1.0	1.5	OC	1	1.0	1.5	OC	1	1.0	1.5	

OPERATING PROFILE

NAME Parker

ALC OC

DATE 5/30/89

ICC MATPCB

SHEET 2 OF 3

PCB
HSI
PIL 96523

WCD CBEY09

WCD DATE 88239

ICD DATE 88227														
OPERATION NUMBER	ICC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW INHIBIT %	MANDATORY FLOW INHIBIT INHS.	MANIPPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
							SKILL CODE/LEVEL	QTY.	%	TIME REQUIRED %	TIME REQUIRED INHS.	EQUIPMENT CODE		QTY.
089	MAT PCB	PROC	1.0	TRANSFER	-	-	CP09	1	1.0	1.0	OC 0973	1	1.0	adjustments multi-step
				PROCESS	-	-								
110		TEST	1.0	TRANSFER	-	-					OC 0973	1	1.0	
				PROCESS	-	-								
120		INSP	1.0	TRANSFER	-	-		1	1.0	1.0	OC 0973	1	1.0	
				PROCESS	-	-								
130		ASSY	1.0	TRANSFER	-	-		1	1.0	1.7	OC 0973	1	1.0	Safety wire, installed
				PROCESS	-	-								
150		PROC	1.0	TRANSFER	-	-		1	1.0	1.50	OC 0973	1	1.0	
				PROCESS	-	-								

NAME Parker

ALC OC

DATE 5/25/53

псс МАТРСБ

SHEET 3 OF 3

11511 96533

WCD CBEY 29

WCD DATE 88239

[illegible]

FLOW PROCESS CHART

SUBJECT MAIN FUEL PUMP FLOW PROCESS CHART DATE 5/30/69

ITEM CODE

PCN
HSH.
F/M

WCD CBEV09 WCD DATE 88239

965-23

CHART BEGINS 010

CHART ENDS 165

PREPARED BY

[illegible]

○ OPERATION

▷ TRANSPORTATION

▽ STORAGE

D DELAY

☐ INSPECTION

"IN" DATES PRC 'LE

NAME _____		ALC <u>QC - ALC</u>		DATE <u>3/11/87</u>		RCC <u>MTPCB</u>		SHEET <u>1</u> OF <u>1</u>	
PCI	ISH	PH	OBSERVATION NUMBER	"II" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	PARENT WCD DATE			
			965123A						
			1	8295	8298				72
			2	8348	8348				0.
			3	8348	8349				24
			4	9004	9004				0
			5	9059	9060				24
			6	9096	9097				24
									(24)

NOTE: "II" DATE IS THE DATE THAT SCHEDULING EMPHENS III BLOCK 5 OF WCD ON DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

"OUT" DATES PROC. LE

NAME		ALC	DATE	RCC	MTPEB	SHEET	OF
PCN		PATIENT					
PIL		WCD DATE					
OBSERVATION NUMBER		LAST OPERATION (COMPLETION DATE)		"OUT" DATE (SCHEDULING SELL DATE)		A TIME (HOUR)	
1	96523A	8302	8302	0			
2		8355	8356	24			
3		8357	8357	0			
4		9009	9009	0			
5		9062	9065	72			
6		9103	9103	0			
				16			

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATION PROFILE

NAME <u>KOBYLAK</u>		ALC <u>OC-ALC</u>		DATE <u>31 MAY 89</u>		RCC <u>MATPCB</u>		SHEET <u>1</u> OF <u>7</u>							
ITEM CODE <u>96555A</u>		WCD <u>CB EY 16</u>		WCD DATE <u>98267</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.				
000		IN	1.0	TRANSIT											
		SETUP													
		PROCESS			0										
010	MAT PCB	REC	1.0	TRANSIT											RECEIVE PART IDENTIFY AND ATTACH PART WORK
		SETUP													MOSTLY PUMPS ARE WORKED ON IMMEDIATELY BUT SOME 4-5 TIMES MAY BE 36 HOURS
		PROCESS				AP09	1	100	25		B0436	1	100	25	WCD 010
015	CB	CLN	1.0	TRANSIT											WASH OUTSIDE OF PUMP
		SETUP													BLOW OUTSIDE WITH AIR
		PROCESS				AP09	1	100	25		00178	1	100	25	
020	CB	DIS	1.0	TRANSIT											DISASSEMBLE PUMP, DEWIRE & BREAK DOWN. SAME PARTS GO BACK INTO SAME PUMP
		SETUP			1										
		PROCESS													
030	CB	CLN	1.0	TRANSIT											WCD 020
		SETUP													DEGREASE
		PROCESS				AP09	1	100	25		004947	1	100	25	WCD 030

OPERATION PROFILE

NAME <u>KOBYLK</u>		ALC <u>OC-ALC</u>		DATE <u>31 MAY 89</u>		RCC <u>MAT PCB</u>		SHEET <u>2</u> OF <u>7</u>							
ITEM CODE <u>96555A</u>		WCD <u>CBF716</u>		WCD DATE <u>88267</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED HRS.	DATA SOURCE COMMENTS			
							QTY.	%	QTY.	%					
050	CB	INSP	1.0	TRANSIT	20	BIOA			OC0229	1	2.0	NOT FLUORESCENT PENETRANT INSPECTION			
				SETUP											
				PROCESS											
052	CB	INSP	1.0	TRANSIT								VCD 0504060 VISUAL INSPECTION OF PART			
				SETUP											
				PROCESS											
054	CB	INSP	1.0	TRANSIT					B0436	1	.2	INSPECT DRUM JOURNAL AND IMPELLER END (A)			
				SETUP											
				PROCESS											
058	CB	INSP	1.0	TRANSIT	1				B0436	1	.2	INSPECT SEALING SURFACES (B)			
				SETUP											
				PROCESS											
062	CB	INSP	1.0	TRANSIT					B0436	1	.3	INSPECT LOCK NUT AND IMPELLER LAP (C)			
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME <u>KOBYLK</u>		ALC <u>OC-ALC</u>		DATE <u>31 MAY 84</u>		RCC <u>MAAT PCB</u>		SHEET <u>3</u> OF <u>7</u>						
ITEM CODE <u>96555A</u>		WCD <u>CBE/116</u>		WCD DATE <u>08267</u>										
OPERATION NUMBER	NOC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED %	HRS.	DATA SOURCE COMMENTS	
							QTY.	%	QTY.	%				
064	CB	INSP	1.0	TRANSIT									INJECT FOUNDS I (0)	
		SETUP												
		PROCESS				AP09	1	100	5	B0436	1	100	5	040
066	CB	INSP	1.0	TRANSIT									INSPECT VALUE BODY I.D. (E)	
		SETUP												
		PROCESS				AP09	1	100	2	B0436	1	100	2	040
068	CB	INSP	1.0	TRANSIT									F,6,J BEARING INSPECTIONS	
		SETUP												
		PROCESS				AP09	1	100	1.0	B0436	1	100	1.0	040
070	CB	PROC	.9	TRANSIT									MACHINE SHOP + PLATING ALCO, MOVE TO FURNACE FOR ONE 25 AT A TIME IMPACT + HOLDING	
		SETUP			32.100								WCD 070	
		PROCESS											REPAIR + REPLACE PARTS AS REQUIRED	
080	CB	REP	1.0	TRANSIT									WCD 080	
		SETUP												
		PROCESS				AP09	1	100	.75	B0436	1	100	.75	

OPERATION PROFILE

NAME <u>KOBYLK</u>		ALC <u>OC-ALC</u>		DATE <u>31 MAY 89</u>		RCC <u>MAT PCB</u>		SHEET <u>4</u> OF <u>7</u>					
ITEM CODE <u>PCN 96555A</u>		WCD <u>CB 116</u>		WCD DATE <u>88257</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
							QTY.	%	QTY.	%			
090	CB	ASSY	1.0	TRANSIT									PARTIAL ASSY MBL
				SETUP									
				PROCESS									
095	CB	ASSY	1.0	TRANSIT									WCD 090 CHECK LINES BEFORE INSTALLING
				SETUP									
				PROCESS									
120	CB	TEST	1.0	TRANSIT									WCD 090 TEST FOR LEAKAGE
				SETUP									
				PROCESS									
140	CB	ASSY	1.0	TRANSIT									WCD 120 AND 130 ASSEMBLE ELBOW + TORQUE DOCS
				SETUP									
				PROCESS									
150	CB	ASSY	1.0	TRANSIT									WCD 140 ASSEMBLE PUMP IN STAGES
				SETUP									
				PROCESS									

OPERATION PROFILE

NAME <u>KOBYLK</u>		ALC <u>QC-ALC</u>		DATE <u>31 MAY 89</u>		RCC <u>MATPCB</u>		SHEET <u>5</u> OF <u>7</u>				
ITEM CODE <u>96553A</u>		WCD <u>CBEY16</u>		WCD DATE <u>08067</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.		EQUIPMENT CODE	QTY.
155	CB	PROC	1.0	TRANSIT						BUILD BEELEVILLE SPRINGS		
				SETUP								
				PROCESS								
160	CB	PROC	1.0	TRANSIT						ASSEMBLY BLARINOS AND ALLIEN		
				SETUP								
				PROCESS								
165	CB	PROC	1.0	TRANSIT						MIC CLEARANCES BLARINOS SPA CLUTCH OUTER SLEEVE		
				SETUP								
				PROCESS								
170	CB	PROC	1.0	TRANSIT						ASSEMBLY AND MEASUREMENTS CLEARANCES OF DRIVE SHAFT		
				SETUP								
				PROCESS								
174	CB	TEST	1.0	TRANSIT						WCD 170 DO IMPPELLER RUNOUT TEST		
				SETUP								
				PROCESS								

OPERATION PROFILE

NAME <u>KOBYLK</u>		ALC <u>OC-ALC</u>		DATE <u>31 MAY 89</u>		RCC <u>MAT PCB</u>		SHEET <u>6</u> OF <u>7</u>							
ITEM CODE <u>96555A</u>		WCD <u>CB-Y16</u>		WCD DATE <u>80267</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.				%
176 CB		PROC	1.0	TRANSIT											BALANCE DRIVE START
				SETUP											
				PROCESS											
180 CB		PROC	1.0	TRANSIT											WCD 170 CHECK BODY/BOLT
				SETUP											
				PROCESS											
190 CB		PROC	1.0	TRANSIT											WCD 180 CHECK CLEARANCE
				SETUP											
				PROCESS											
200 CB		PROC	1.0	TRANSIT											WCD 190 TORQUE & VACUUM CHECK
				SETUP											
				PROCESS											
210 MAT PCB		TEST	1.0	TRANSIT											WCD 200 TEST BUILDING 3108 CB-Y17
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME <u>KOBVICK</u>		ALC <u>OC-ALC</u>		DATE <u>31 MAY 89</u>		RCC <u>MAT PCB</u>		SHEET <u>7</u> OF <u>7</u>					
PCN <u>96555A</u>		WCD <u>CBF16</u>		WCD DATE <u>88267</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			TIME REQUIRED HRS.	DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %			
215	MAT PCB	PROC	1.0	TRANSIT									CHECK POCKET VALVE TORQUE, RETORQUE AND LOCKWIRE
				SETUP									
				PROCESS									
220	CB	PAPER WORK	1.0	TRANSIT									WCD 215 COMPLETE PAPER WORK
				SETUP									
				PROCESS									
9999		OUT	1.0	TRANSIT									WCD 220 & 230
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

FLOW PROCESS CHART

SUBJECT

A B FUEL PUMP

DATE 31 MAY 89

ITEM CODE

WCD CBEY16

WCD DATE

88267

PCN

NBN

PM

000

96555A

CHART BEGINS

000 (INI)

CHART ENDS

999 (OUT)

PREPARED BY KOBILK

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
0000	—	○●□□▽	IN	220	220	●□□□▽	PARTIAL WORK
010	010	●□□□▽	RETURN IDENTIFY PUMP	—	230	●□□□▽	PARTIAL WORK
015	—	●□□□▽	CLEAN OUTSIDE OF PUMP	9999	OUT	○●□□▽	
020	020	●□□□▽	DISASSEMBLY			○●□□▽	
030	030	●□□□▽	DECREASE PUMP			○●□□▽	
050	050	○●□□▽	PERMIT FLOW			○●□□▽	
—	060	○●□□▽	MAGNETIC			○●□□▽	
052	040	○●□□▽	VISUAL INSPECTION			○●□□▽	
054	040	○●□□▽	INSPECT DRIVE JOURNALS			○●□□▽	
058	040	○●□□▽	SEALING SURFACE			○●□□▽	
062	040	○●□□▽	LOCK NUT & IMPELLER			○●□□▽	
064	040	○●□□▽	HOUSING I.D.			○●□□▽	
066	040	○●□□▽	VALVE BODY I.D.			○●□□▽	
068	040	○●□□▽	BEARINGS			○●□□▽	
070	070	●□□□▽	MACHINE SHOP PLATING			○●□□▽	
080	080	●□□□▽	REPAIR			○●□□▽	
090	090	●□□□▽	ASSEMBLY			○●□□▽	
095	090	●□□□▽	INSPECT INSTALL LINING			○●□□▽	
120	120	●□□□▽	TEST SETUP			○●□□▽	
—	130	●□□□▽	TEST			○●□□▽	
140	140	●□□□▽	ASSEMBLY FLOW			○●□□▽	
150	150	●□□□▽	ASSEMBLY			○●□□▽	
155	—	●□□□▽	BUILD SPRINGS			○●□□▽	
160	160	●□□□▽	ASSEMBLY BEARINGS			○●□□▽	
170	170	●□□□▽	ASSEMBLY DRIVE SHAFT			○●□□▽	
174	—	●□□□▽	IMPELLER RING			○●□□▽	
176	170	●□□□▽	DRIVE SHAFT RUNOUT			○●□□▽	
180	180	●□□□▽	CHECK BODY BOLT			○●□□▽	
190	190	●□□□▽	IMPELLER CLEARANCE			○●□□▽	
200	200	●□□□▽	FORGET VACUUM CHECK			○●□□▽	
210	210	●□□□▽	GO TO TEST CELL			○●□□▽	
215	215	●□□□▽	POPE VALVE			○●□□▽	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

D DELAY

LSC-20147

JANE KOBLYK

ALC OC-ALC

DATE _____

DATE 31 MAR 89

100

12

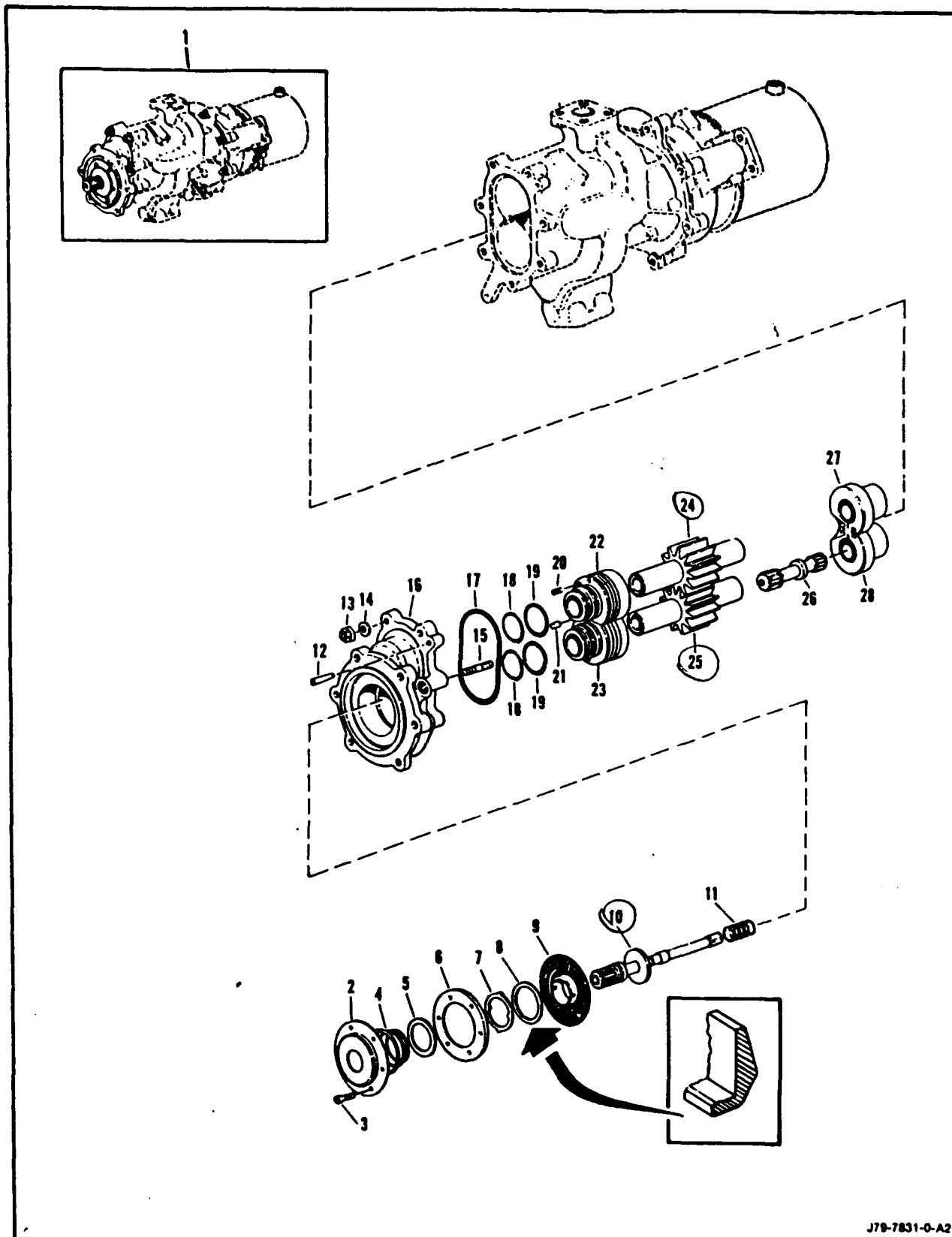
1 of 1

1

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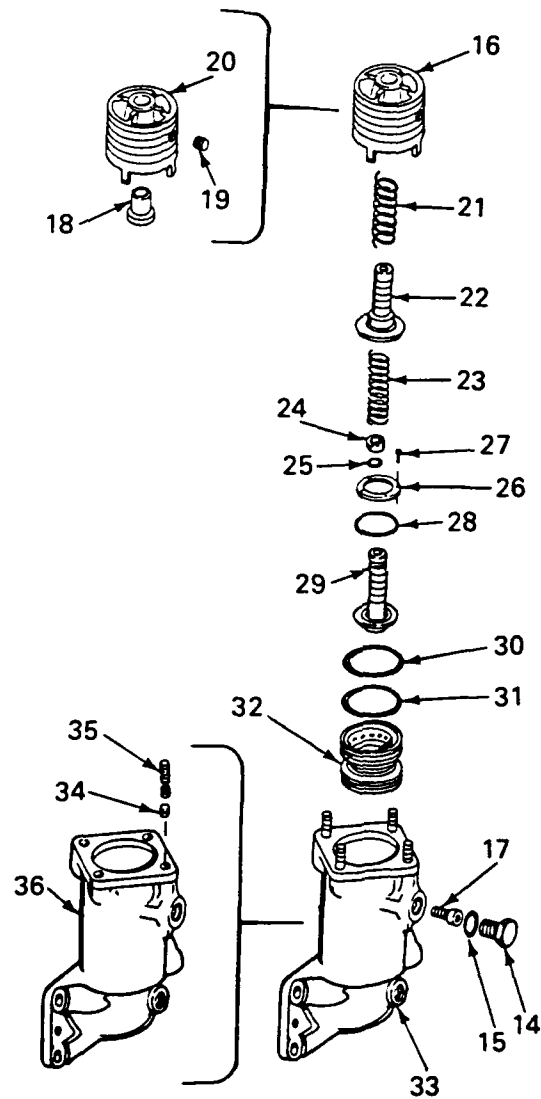
LSC-2(XH)SA

SECTION II
GROUP ASSEMBLY PARTS LIST



J79-7831-0-A2

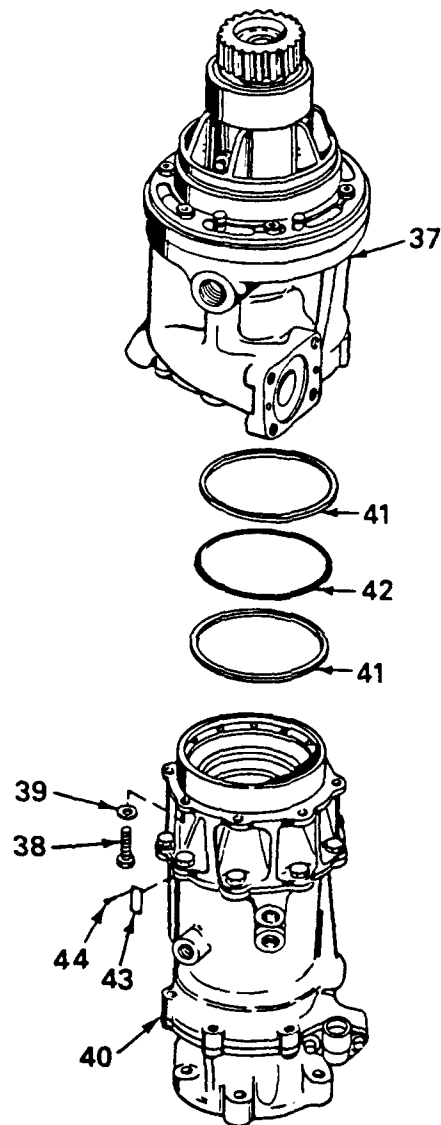
Figure 1. Exploded View of Fuel Pump Assembly (Sheet 1 of 3)



A-52046

Figure 1. Centrifugal Pump Assembly (Sheet 2 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
1/1-	024536-209-09	99167		PUMP ASSEMBLY, Centrifugal . (Repair Kit Available)	REF	A	PAOLD
	025264-200-02	99167		PUMP ASSEMBLY, Centrifugal .	REF	B	PAOLD
	024536-213-09	99167		PUMP ASSEMBLY, Centrifugal .	REF	C	PAOLD
	024536-214-10	99167		PUMP ASSEMBLY, Centrifugal .	REF	D	PAOLD
-1	02-14887	99167	.	FILTER, Oil	1		PAOZZ
-2	99-2975-8	99167	.	PACKING, Preformed	1		PAOZZ
-3	102-1381	99167	.	VALVE ASSEMBLY, Poppet . .	1	A	PAOZZ
	102-1381-01	99167	.	VALVE ASSEMBLY, Poppet . . (see figure 2)	1	BCD	PAOZZ
-4	99-2975-5	99167	.	PACKING, Preformed	1	A	PADZZ
	99-4602-05	99167	.	PACKING, Preformed	1	BCD	PADZZ
-5	102-1478	99167	.	FILTER ASSEMBLY (see . . . figure 3)	1	B	PADZZ
-6	99-4602-05	99167	.	PACKING, Preformed	1	B	PAOZZ
-7	02-14731	99167	.	TUBE, Turbine inlet	1		PADZZ
-8	99-4346-112	99167	.	PACKING, Preformed	2	A	PADZZ
	99-4601-112	99167	.	PACKING, Preformed	2	BCD	PADZZ
-9	99-4498	99167	.	RETAINER	2		PADZZ
-10	99-4195-06	99167	.	SCREW, Cap (AP)	4		PADZZ
-11	99-4344	99167	.	WASHER (AP)	4		PADZZ
-12	99-4346-221	99167	.	PACKING, Preformed	1	A	PADZZ
	99-4601-221	99167	.	PACKING, Preformed	1	BCD	PADZZ
-13	99-4345	99167	.	CAP SEAL	1		PADZZ

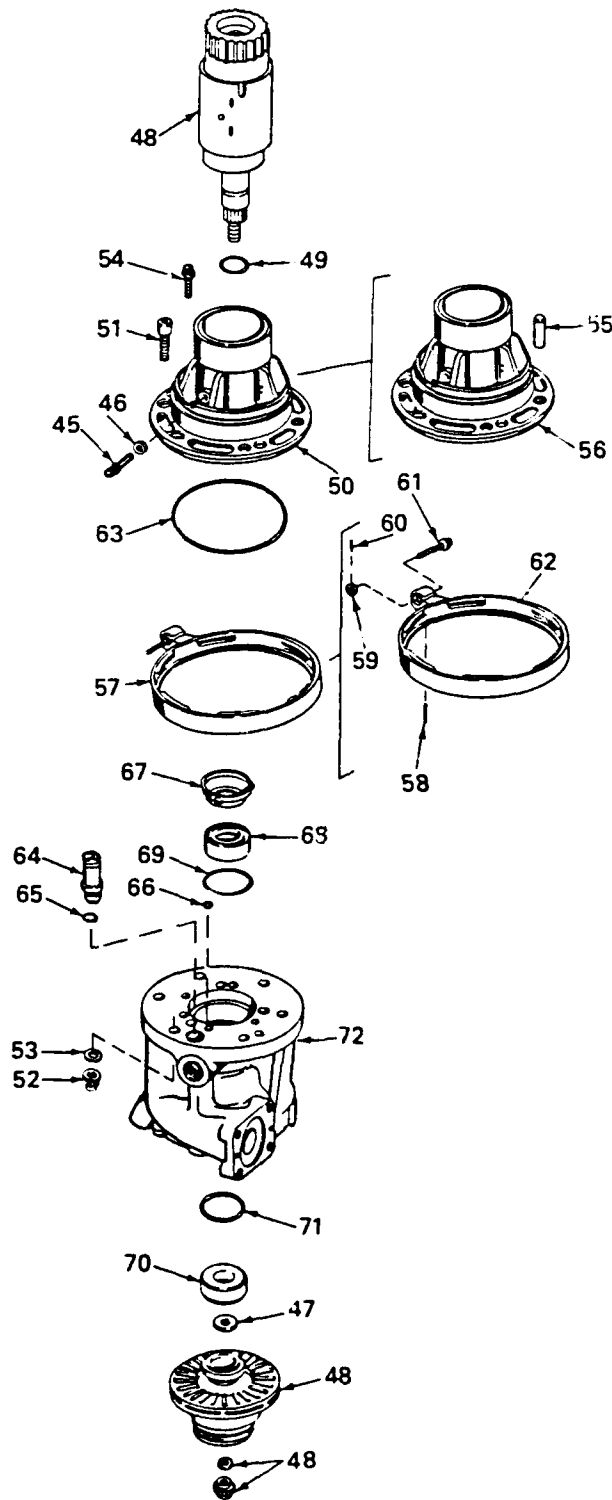


A-52651

Figure 1. Centrifugal Pump Assembly (Sheet 3 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
1/2-							
-14	AN814-4L	88044	.	PLUG	1		PADZZ
-15	99-2975-4	99167	.	PACKING, Preformed	1	A	PAOZZ
	99-4602-04	99167	.	PACKING, Preformed	1	BCD	PAOZZ
-16	102-1231-01	99167	.	GUIDE SUBASSEMBLY, Flow . .	1		PADZZ
-17	99-4196-02	99167	.	SCREW, Socket head (AP) . .	1		PADZZ
-18	02-14781	99167	.	GUIDE, Valve	1		PADZZ
-19	MS21209F4-15	96906	.	INSERT	1		PADZZ
-20	02-14801-01	99167	.	GUIDE, Flow	1		PADZZ
-21	99-4303	99167	.	SPRING, High pressure check valve	1		PADZZ
-22	02-14875-02	99167	.	VALVE, High pressure check	1		PADZZ
-23	99-4304	99167	.	SPRING, Low pressure check valve	1		PADZZ
-24	99-4302	99167	.	RING, Glyd	1		PADZZ
-25	99-2973-6	99167	.	PACKING, Preformed	1		PADZZ
-26	02-15301	99167	.	RETAINER, Packing	1	ACD	PADZZ
	02-15301-01	99167	.	RETAINER, Packing	1	B	PADZZ
-27	99-4581	99167	.	SCREW, Flat head (AP) . . .	6		PADZZ
-28	99-4580	99167	.	PACKING, Preformed	1		PADZZ
-29	02-15302	99167	.	VALVE, Low pressure check .	1		PADZZ
-30	99-2973-127	99167	.	PACKING, Preformed	1		PADZZ
-31	99-2973-127	99167	.	PACKING, Preformed	1	A	PADZZ
	99-4601-127	99167	.	PACKING, Preformed	1	BCD	PADZZ
-32	02-15397	99167	.	SEAT, Check valve	1		PADZZ
-33	102-1235-02	99167	.	VALVE HOUSING SUBASSEMBLY, Check	1		PADZZ
-34	KR5A-15	99057	.	RING, Key	4		PADZZ
-35	99-4186	99167	.	STUD	4		PADZZ
-36	02-14808-02	99167	.	HOUSING, Valve	1		PADLD

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
1/3-							
-37	No Number	99167	.	PUMP UNIT ASSEMBLY	1		PADBZ
-38	99-4190	99167	.	BOLT (AP)	8		PADZZ
-39	AN960-516L	88044	.	WASHER (AP)	8		PADZZ
-40	102-1302-02	99167	.	INLET VALVE & INDUCER . . .	1	A	PADZZ
				SUBASSEMBLY (see figure 4)			
	102-1561-03	99167	.	INLET VALVE & INDUCER . . .	1	B	PADZZ
				SUBASSEMBLY (see figure 4)			
	102-1302-05	99167	.	INLET VALVE & INDUCER . . .	1	C	PADZZ
				SUBASSEMBLY (see figure 4)			
	102-1302-06	99167	.	INLET VALVE & INDUCER . . .	1	D	PADZZ
				SUBASSEMBLY (see figure 4)			
-41	99-4496	99167	.	RETAINER, Packing	2		PADZZ
-42	99-4346-241	99167	.	PACKING, Preformed	1	A	PADZZ
	99-4601-241	99167	.	PACKING, Preformed	1	BCD	PADZZ
-43	99-5000-03	99167	.	PLATE, Identification	1		PADZZ
-44	AN535-00-2	88044	.	SCREW (AP)	4		PADZZ



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Figure 1. Centrifugal Pump Assembly (Sheet 4 of 4)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
1/4-							
-45	99-4188	99167	.	BOLT	3		PADZZ
-46	MS20002C4	96906	.	WASHER	1		PADZZ
-47	02-12869-07	99167	.	SHIM (0.001 inch thick) . .	AR	ACD	PADZZ
	02-12869-06	99167	.	SHIM (0.016 inch thick) . .	AR	ACD	PADZZ
	02-12869-05	99167	.	SHIM (0.014 inch thick) . .	AR	ACD	PADZZ
	02-12869-04	99167	.	SHIM (0.012 inch thick) . .	AR	ACD	PADZZ
	02-12869-03	99167	.	SHIM (0.010 inch thick) . .	AR	ACD	PADZZ
	02-12869-02	99167	.	SHIM (0.005 inch thick) . .	AR	ACD	PADZZ
	02-12869-01	99167	.	SHIM (0.003 inch thick) . .	AR	ACD	PADZZ
	02-15827-01	99167	.	SHIM (0.001 inch thick) . .	AR	B	PADZZ
	02-15827-02	99167	.	SHIM (0.003 inch thick) . .	AR	B	PADZZ
	02-15827-03	99167	.	SHIM (0.005 inch thick) . .	AR	B	PADZZ
	02-15827-04	99167	.	SHIM (0.010 inch thick) . .	AR	B	PADZZ
	02-15827-05	99167	.	SHIM (0.012 inch thick) . .	AR	B	PADZZ
	02-15827-06	99167	.	SHIM (0.014 inch thick) . .	AR	B	PADZZ
	02-15827-07	99167	.	SHIM (0.016 inch thick) . .	AR	B	PADZZ
-48	102-1347-04	99167	.	SHAFT ASSEMBLY, Balancing . (see figure 5)	1	ACD	PADZZ
	102-1522-01	99167	.	SHAFT ASSEMBLY, Balancing . (see figure 5)	1	B	PADZZ
-49	99-2973-19	99167	.	RING, Seal	1		PADZZ
-50	102-1142	99167	.	HOUSING SUBASSEMBLY, . . . Bearing	1		PAFDD
-51	99-4368	99167	.	SCREW (AP)	6		PADZZ
-52	LH3830-064	72962	.	NUT (99-4198) (AP)	6		PADZZ
-53	AN960-616L	88044	.	WASHER (AP)	6		PADZZ
-54	99-4194-10	99167	.	BOLT (AP)	3		PADZZ
-55	99-4247	99167	.	PIN, Dowel	1		PADZZ
-56	02-14518	99167	.	HOUSING, Bearing	1		PADBZ
-57	504245	77445	.	NUT, Gearbox, quick disconnect	1	A	PADZZ
	02-16113	77445	.	NUT, Gearbox, quick disconnect (702805)	1	BCD	PADZZ
-58	AN150237	88044	.	PIN	2		PAFZZ
-59	504243	77445	.	COLLAR	1		PAFZZ
-60	AN150212	88044	.	PIN	1		PAFZZ
-61	702086	77445	.	BOLT	1		PAFZZ
-62	No Number	77445	.	NUT, Gearbox quick disconnect	1		XA
-63	99-2973-241	99167	.	RING, Seal	1		PADZZ
-64	02-14533	99167	.	SLEEVE, Oil lube	1		PADZZ
-65	99-2973-13	99167	.	RING, Seal	1		PADZZ
-66	99-2973-10	99167	.	RING, Seal	1		PADZZ
-67	02-14859	99167	.	RETAINER	1		PADZZ
-68	02-14696	99167	.	SEAL, Shaft, oil	1		PADZZ
-69	99-2973-130	99167	.	RING, Seal	1		PADZZ
-70	02-14892-01	99167	.	SEAL, Shaft, fuel	1		PADZZ
-71	99-4448	99167	.	PACKING, Preformed	1	A	PADZZ
	99-4601-501	99167	.	PACKING, Preformed	1	BCD	PADZZ
-72	102-1274-02	99167	.	HOUSING SUBASSEMBLY, Pump . (see figure 6)	1		PADBZ

T.O. 6J10-4-63-4

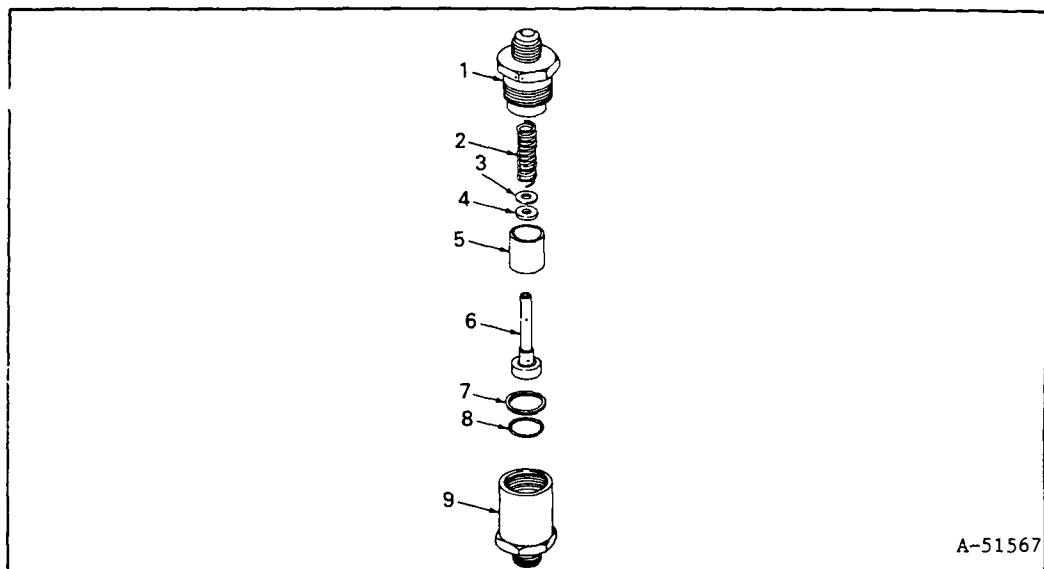
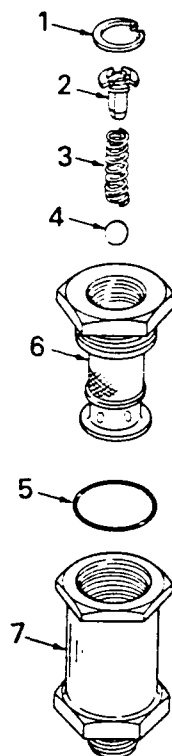


Figure 2. Poppet Valve Assembly

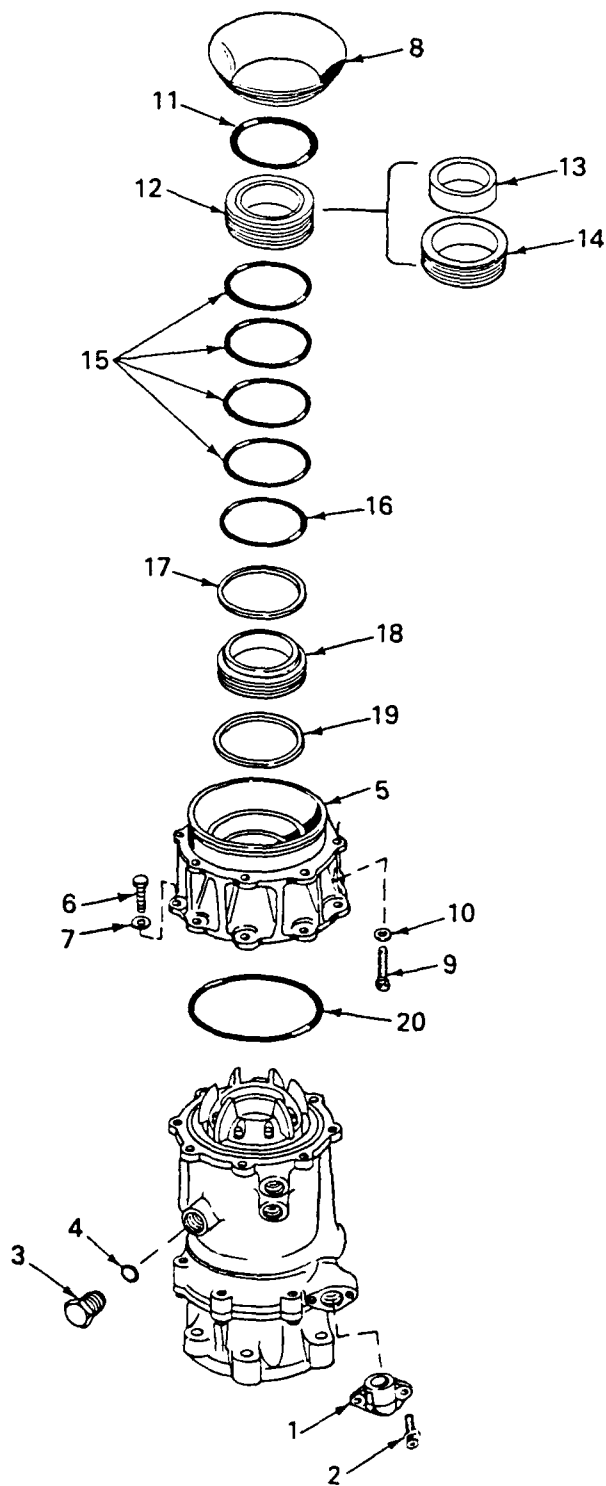
Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
	102-1381	99167		VALVE ASSEMBLY, Poppet (see . index 3, figure 1)	REF	A	PAOZZ
	102-1381-01	99167		VALVE ASSEMBLY, Poppet (see . index 3, figure 1)	REF	BCD	PAOZZ
-1	02-15245	99167		. CAP, Valve	1		PAOZZ
-2	99-4531	99167		. SPRING	1		PAOZZ
-3	02-15246-04	99167		. SPACER (0.005 in. thick) .	AR		PAOZZ
	02-15246-03	99167		. SPACER (0.010 in. thick) .	AR		PAOZZ
	02-15246-02	99167		. SPACER (0.015 in. thick) .	AR		PAOZZ
-4	02-15246-01	99167		. SPACER (0.050 in. thick) .	1		PAOZZ
-5	102-1380	99167		. POPPET ASSEMBLY	1		PAOZZ
-6	02-15243	99167		. SEAT, Valve	1		PAOZZ
-7	99-4533	99167		. RETAINER	1		PAOZZ
-8	99-4346-16	99167		. PACKING, Preformed	1	A	PAOZZ
	99-4601-016	99167		. PACKING, Preformed	1	BCD	PAOZZ
-9	02-15242	99167		. HOUSING, Valve	1		PAOZZ
<u>Usable on Code</u>							
A 024536-209-09							
B 025264-200-02							
C 024536-213-09							
D 024536-214-10							



A-51569

Figure 3. Filter Assembly

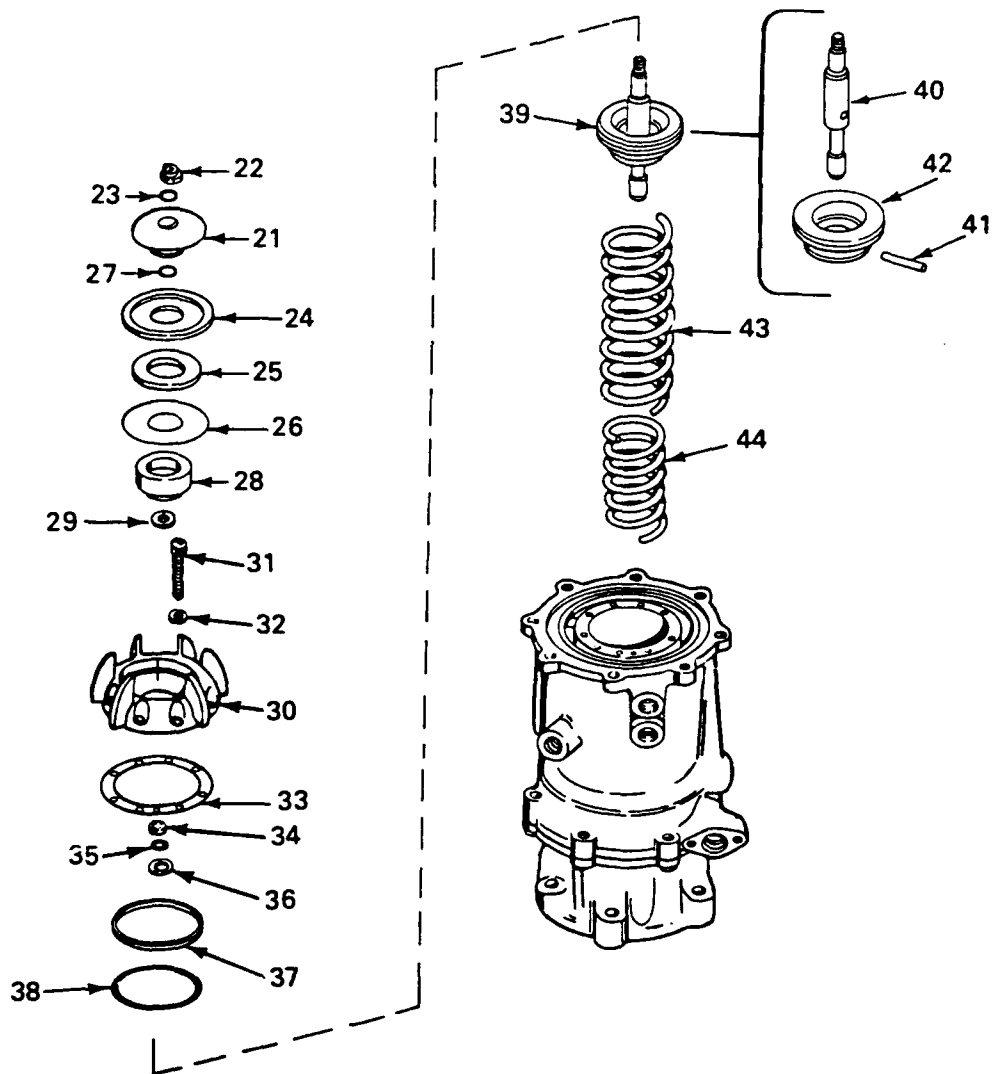
Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
3-	102-1478	99167		FILTER ASSEMBLY (see index 5, figure 1)	REF	B	PAOZZ
-1	102-1482	99167		. FILTER	1	B	PAOZZ
-2	99-4601-017	99167		. PACKING, Preformed	1	B	PAOZZ
-3	MS16625-4045	96906		. RING, Retaining	1	B	PAOZZ
-4	02-15584	99167		. RETAINER, Spring	1	B	PAOZZ
-5	99-4777	99167		. SPRING, Filter bypass	1	B	PAOZZ
-6	MS134356	96906		. BALL	1	B	PAOZZ
-7	02-15582	99167		. HOUSING, Filter	1	B	PAOZZ
<u>Usable On Code</u>							
A 024536-209-09							
B 025264-200-02							
C 024536-213-09							
D 024536-214-10							



A-52666

Figure 4. Inlet Valve and Inducer Subassembly (Sheet 1 of 3)

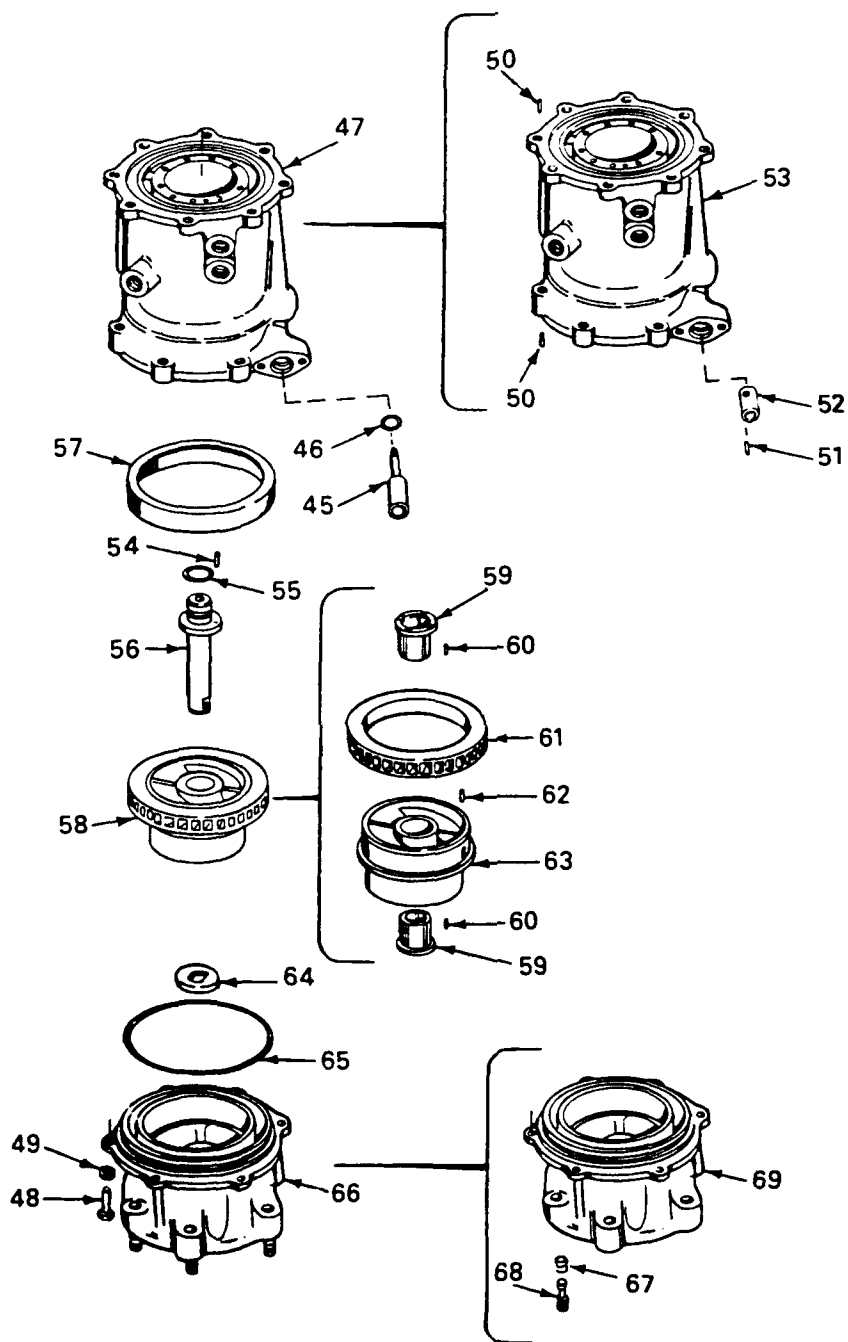
Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
4/1-	102-1302-02	99167		INLET VALVE & INDUCER SUBASSEMBLY (see index 40, figure 1)	REF	A	PADLD
	102-1561-03	99167		INLET VALVE & INDUCER SUBASSEMBLY (see index 40, figure 1)	REF	B	PADLD
	102-1302-05	99167		INLET VALVE & INDUCER SUBASSEMBLY (see index 40, figure 1)	REF	C	PADLD
	102-1302-06	99167		INLET VALVE & INDUCER SUBASSEMBLY (see index 40, figure 1)	REF	D	PADLD
-1	02-14723-02	99167		. ELBOW, Turbine inlet . . .	1		PADZZ
-2	99-4203-06	99167		. BOLT, Twelve point head (AP)	2		PADZZ
-3	AN814-4L	88044		. PLUG	1		PADZZ
-4	99-2975-4	99167		. RING, Seal	1	A	PADZZ
	99-4602-04	99167		. PACKING, Preformed	1	BCD	PADZZ
-5	02-14999	99167		. COVER, Impeller	1	AC	PADLD
	02-14999-01	99167		. COVER, Impeller	1	BD	PADLD
-6	99-4191	99167		. BOLT (AP)	8		PADZZ
-7	AN960-416	88044		. WASHER (AP)	8		PADZZ
-8	02-15000-01	99167		. LINER, Impeller cover . . .	1		PADZZ
-9	99-4394-07	99167		. SCREW (AP)	8		PADZZ
-10	NAS620-8	80205		. WASHER (AP)	8		PADZZ
-11	99-4346-234	99167		. PACKING, Preformed		A	PADZZ
	99-4601-234	99167		. PACKING, Preformed		BCD	PADZZ
-12	102-1288-01	99167		. RING SUBASSEMBLY, Wear . .	1		PADZZ
-13	02-14852	99167		. . RING, Wear	1		PADZZ
-14	02-14964	99167		. . RETAINER, Wear ring . . .	1		PADZZ
-15	99-2973-38	99167		. RING, Seal	4		PADZZ
-16	99-2973-142	99167		. RING, Seal	1	A	PADZZ
	99-4601-142	99167		. PACKING, Preformed	1	BCD	PADZZ
-17	99-4630	99167		. RETAINER, Packing backup .	1	BD	PADZZ
-18	02-14855	99167		. SEAT, Valve inlet	1	AC	PADZZ
	02-15825	99167		. SEAT, Valve inlet	1	B	PADZZ
	02-15383	99167		. SEAT, Valve inlet	1	D	PADZZ
-19	02-15001-01	99167		. SHIM (0.002 inch thick) . .	AR		PADZZ
	02-15001-02	99167		. SHIM (0.005 inch thick) . .	AR		PADZZ
	02-15001-03	99167		. SHIM (0.010 inch thick) . .	AR		PADZZ
-20	99-4346-240	99167		. PACKING, Preformed	1	A	PADZZ
	99-4601-240	99167		. PACKING, Preformed	1	BCD	PADZZ



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Figure 4. Inlet Valve and Inducer Subassembly (Sheet 2 of 3)

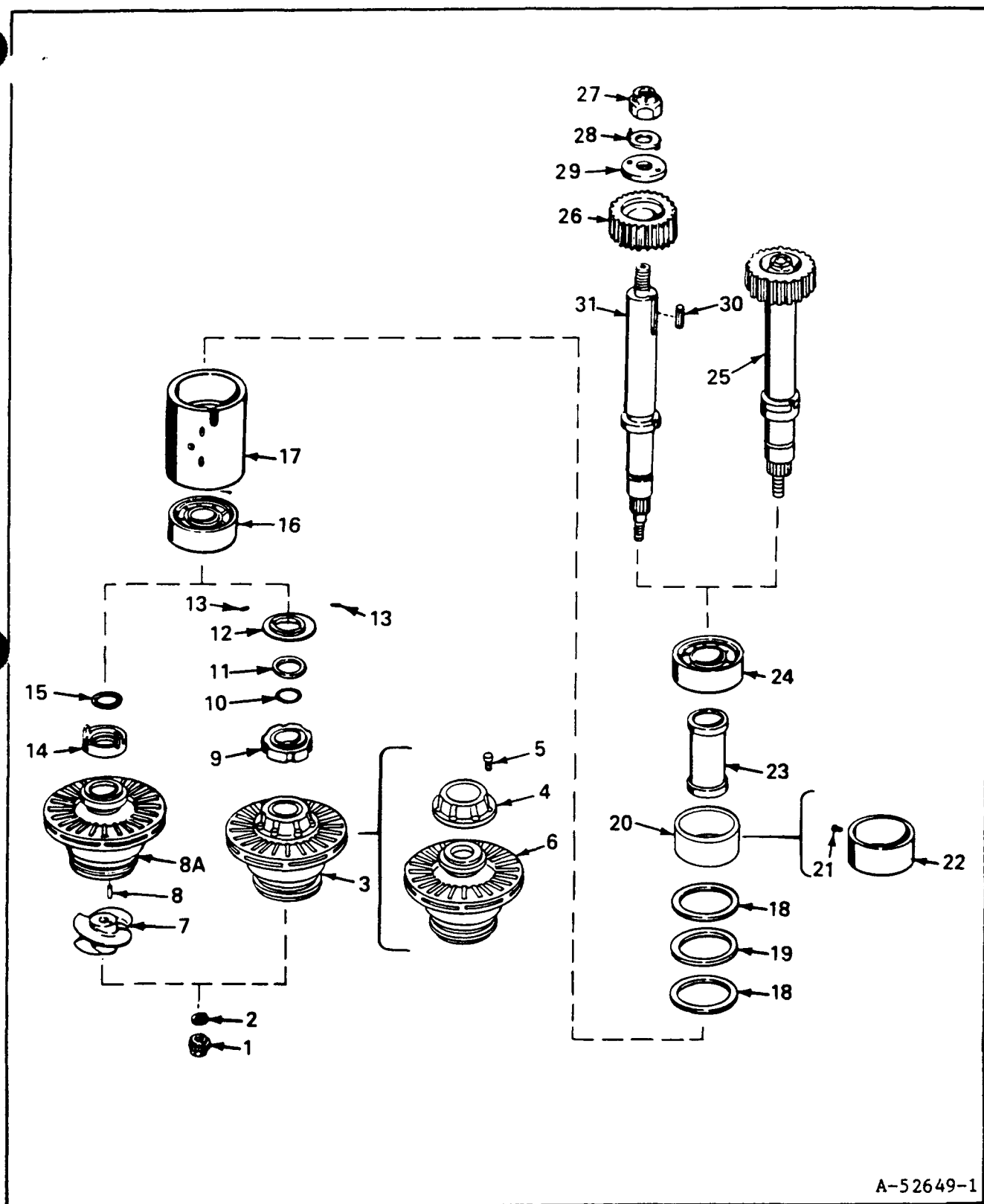
Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
4/2-							
-21	02-14182-01	99167	.	RETAINER, Seal	1		PADZZ
-22	MS20365 -1032C	96906	.	NUT (AP)	1		PADZZ
-23	AN960C10	88044	.	WASHER (AP)	1		PADZZ
-24	02-14183	9167	.	DIAPHRAGM	1		PADZZ
-25	02-14184	99167	.	WASHER	1		PADZZ
-26	02-14914	99167	.	SPRING, Diaphragm	1		PADZZ
-27	99-2973-9	99167	.	RING, Seal	1	A	PADZZ
	99-4601-009	99167	.	PACKING, Preformed	1	BCD	PADZZ
-28	02-13704	99167	.	RETAINER	1		PADZZ
-29	02-12793-01	99167	.	SPACER (0.024 to 0.025 . . inch thick)	AR		PADZZ
	02-12793-02	99167	.	SPACER (0.029 to 0.030 . . inch thick)	AR		PADZZ
	02-12793-03	99167	.	SPACER (0.034 to 0.035 . . inch thick)	AR		PADZZ
	02-12793-04	99167	.	SPACER (0.039 to 0.040 . . inch thick)	AR		PADZZ
	02-12793-05	99167	.	SPACER (0.044 to 0.045 . . inch thick)	AR		PADZZ
-30	02-14745-01	99167	.	HEAD, Piston	1		PADZZ
-31	99-4193-04	99167	.	SCREW, Socket Head (AP) . .	9		PADZZ
-32	NAS620-8	80205	.	WASHER (AP)	9		PADZZ
-33	02-12826	99167	.	GASKET, Piston head	1		PADZZ
-34	99-4352	99167	.	SEAL, Channel	1		PADZZ
-35	99-4351	99167	.	RING, Seal	1	A	PADZZ
	99-4601-110	99167	.	PACKING, Preformed	1	BCD	PADZZ
-36	02-13070	99167	.	PLUG	1		PADZZ
-37	99-4288	99167	.	RING, Glyd	1		PADZZ
-38	99-4287	99167	.	RING, Seal	1	A	PADZZ
	99-4601-500	99167	.	PACKING, Preformed	1	BCD	PADZZ
-39	102-1213	99167	.	ROD SUBASSEMBLY, Piston . .	1		PADZZ
-40	02-14762	99167	.	PISTON, Inlet valve	1		PADZZ
-41	MS16555-631	96906	.	PIN	1		PADZZ
-42	02-14761	99167	.	ROD, Piston	1		PADZZ
-43	99-4319	99167	.	SPRING, Inlet valve	1		PADZZ
-44	99-4318	99167	.	SPRING, Inlet valve	1		PADZZ



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Figure 4. Inlet Valve and Inducer Subassembly (Sheet 3 of 3)

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
4/3-							
-45	02-14794-01	99167	.	NOZZLE, Turbine inlet . . .	1	ACD	PADZZ
	02-15824	99167	.	NOZZLE, Turbine inlet . . .	1	B	PADZZ
-46	99-4346-16	99167	.	PACKING, Preformed . . .	1	A	PADZZ
	99-4601-016	99167	.	PACKING, Preformed . . .	1	BCD	PADZZ
-47	102-1352	99167	.	HOUSING SUBASSEMBLY, . . .	1		PADBZ
				Inlet valve			
-48	99-4191	99167	.	BOLT (AP)	6		PADZZ
-49	AN960-416	88044	.	WASHER (AP)	6		PADZZ
-50	MS16556-825	96906	.	PIN	2		PADZZ
-51	MS171432	96906	.	PIN, Spring	1		PADZZ
-52	02-15010-01	99167	.	INSERT	1		PADZZ
-53	02-14795-02	99167	.	HOUSING	1		PADBZ
-54	MS9105-30	96906	.	PIN	1		PADZZ
-55	99-2973-12	99167	.	RING, Seal	1	A	PADZZ
	99-4601-012	99167	.	PACKING, Preformed	1	BCD	PADZZ
-56	02-14912	99167	.	SHAFT, Inducer	1	ACD	PADZZ
	02-15826-01	99167	.	SHAFT, Inducer	1	B	PADZZ
-57	02-14881	99167	.	LINER, Inlet valve	1		PADZZ
				housing			
-58	102-1224	99167	.	INDUCER SUBASSEMBLY, . . .	1	ACD	PADZZ
				Turbine			
	102-1562-02	99167	.	INDUCER SUBASSEMBLY, . . .	1	B	PADZZ
				Turbine			
-59	02-14566	99167	.	BEARING, Inducer	2		PADZZ
-60	99-2350	99167	.	PIN	2		PADZZ
-61	02-14850	99167	.	WHEEL, Turbine	1		PADZZ
-62	MS9105-27	96906	.	PIN	1		PALZZ
-63	02-14785	99167	.	INDUCER, Shrouded	1	ACD	PADZZ
	02-15830-01	99167	.	INDUCER, Shrouded	1	B	PADZZ
-64	02-14211	99167	.	WASHER, Thrust	1		PADZZ
-65	99-4346-240	99167	.	PACKING, Preformed	1	A	PADZZ
	99-4601-240	99167	.	PACKING, Preformed	1	BCD	PADZZ
-66	102-1207-01	99167	.	HOUSING SUBASSEMBLY, . . .	1	ACD	PADBZ
				Inducer			
	102-1559-02	99167	.	HOUSING SUBASSEMBLY, . . .	1	B	PADBZ
				Inducer			
-67	KR6A-15	99057	.	RING, Key (99-4000-6) . .	6		PADZZ
-68	99-3371	99167	.	STUD	6		PADZZ
-69	02-14534-02	99167	.	HOUSING, Inducer	1	ACD	PADBZ
	02-15823-02	99167	.	HOUSING, Inducer	1	B	PADBZ
Usable On Code							
A 024536-209-09							
B 025264-200-02							
C 024536-213-09							
D 024536-214-10							



A-52649-1

Figure 5. Balancing Shaft Assembly

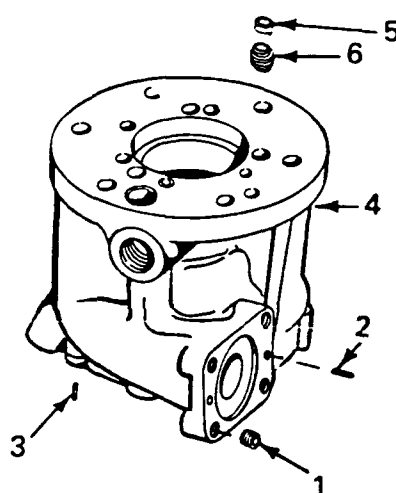
Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
5-	102-1347-04	99167		SHAFT ASSEMBLY, Balancing . . (see index 48, figure 1)	REF	ACD	PADZZ
	102-1522-01	99167		SHAFT ASSEMBLY, Balancing . .	REF	B	PADZZ
-1	119FW428	56878		. LOCKNUT (99-4197-02) . . .	1		PADZZ
-2	NAS620-416L	80205		. WASHER	1	ACD	PADZZ
	NAS620-416	80205		. WASHER	1	B	PADZZ
-3	102-1258-01	99167		. IMPELLER ASSEMBLY (Note 1)	1	ACD	PADDD
-4	02-15279	99167		. . SHROUD (Note 1)	NP	ACD	
-5	99-4567-04	99167		. . SCREW (Note 1)	NP	ACD	
-6	02-15280	99167		. . IMPELLER SUBASSEMBLY . . (Note 1)	NP	ACD	
-7	02-15828	99167		. INDUCER	1	B	PADZZ
	102-1560	99167		. IMPELLER ASSEMBLY	1	B	PADDD
-8	MS16555-602	96906		. . PIN, STRAIGHT, HEADLESS .	1	B	PADZZ
-8A	02-15829	99167		. . IMPELLER	1	B	PADZZ
-9	02-14711-01	99167		. LOCKNUT	1	ACD	PADZZ
-10	99-2973-20	99167		. RING, Seal	1	ACD	PADZZ
-11	MS28774-020	96906		. RETAINER, Backup	1	ACD	PADZZ
-12	02-14712-01	99167		. LOCKWASHER	1	ACD	PADZZ
-13	MS16555-602	96906		. PIN, Straight, headless . .	2	ACD	PADZZ
-14	02-15289-01	99167		. RING, Rotating seal	1	B	PADZZ
-15	99-2973-21	99167		. RING, Seal	1	B	PADZZ
-16	VJ305AS7DA	43334		. BEARING, Ball (99-4019) . .	1		PADZZ
	M305JX2014	70854		. BEARING, Ball (99-4019) . .	1		PADZZ
-17	02-14530-01	99167		. SLEEVE, Outer	1		PADZZ
-18	99-3999	99167		. SPRING, Belleville	2		PADZZ
-19	02-14125	99167		. RING	1		PADZZ
-20	102-1149	99167		. SPACER SUBASSEMBLY	1		
-21	99-3987	99167		. . PIN	1		PADZZ
-22	02-14528	99167		. . SPACER	1		PADZZ
-23	02-14724-01	99167		. SPACER, Bearing	1		PADZZ
-24	VJ305AS7DA	43334		. BEARING, Ball (99-4019) . .	1		PADZZ
	M305JX2014	70854		. BEARING, Ball (99-4019) . .	1		PADZZ
-25	02-14709-03	99167		. SHAFT, Drive	1	ACD	PADZZ
-26	02-15293	99167		. GEAR, Spur	1	B	PADZZ
-27	MS21046C8	96906		. NUT, Self-locking (AP) . .	1	B	PADZZ
-28	MS9276-14	96906		. WASHER, Key (AP)	1	B	PADZZ
-29	02-15292-01	99167		. WASHER (AP)	1	B	PADZZ
-30	02-15294	99167		. KEY, Machine	1	B	PADZZ
-31	02-15288-01	99167		. SHAFT, Shouldered	1	B	PADZZ

Figure & Index Number	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
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Note 1: Two configurations of the impeller exist under the same part number 102-1258-01. The original configuration consists of impeller subassembly 02-15280, shroud 02-15279, and six screws 99-4567-04. The second configuration is a one-piece casting deleting all of the piece parts. Both configurations are usable and interchangeable, but the original configuration is no longer procurable.

Usable On Code

A	024536-209-09
B	025264-200-02
C	024536-213-09
D	024536-214-10



A-52632

Figure 6. Pump Housing Subassembly

Figure & Index mber	Part Number	FSCM	1 2 3 4 5 6 7	Description	Units Per Assy.	Usable on Code	SMR
6-	102-1274-02	99167		HOUSING SUBASSEMBLY, Pump . . (see index 72, figure 1)	REF		PADBZ
-1	MS21208C5-15	96906	.	INSERT	4		PADZZ
-2	MS16566-825	96906	.	PIN	1		PADZZ
-3	MS16556-840	96906	.	PIN	2		PADZZ
-4	02-14882-02	99167	.	HOUSING, Pump	1		PADBZ
-5	KR6-15	99057	.	. RING, Key (99-4011-7) . .	3		PADZZ
-6	L246-7-6S-PF	99057	.	. INSERT (99-4187)	3		PADZZ
	32-0455	99167		PARTS KIT, PUMP, FIELD . . . (Leakproof)	1		
	99-2975-6	99167	.	PACKING, Preformed (KF) . .	1		
	99-5000-23	99167	.	TAG, Warning (KF)	2		
	99-4381	99167	.	PLUG, Shipping (KF)	1		
	99-4221	99167	.	CAP, Shipping (KF)	1		
	99-4058	99167	.	BLOCK, Shipping, Outlet (KF)	1		
	AF325-4		.	NUT (KF) (AP)	2		
	AN960-416		.	WASHER (KF) (AP)	2		
	99-4059	99167	.	GASKET, Shipping, Outlet . (KF)	1		
	99-2198	99167	.	PLUG, Shipping (KF)	2		
	99-4200	99167	.	PLUG, Shipping (KF)	1		
	99-4380	99167	.	CAP, Shipping (KF)	1		
	02-15234	99167	.	BLOCK, Shipping, Inlet (KF)	1		
	AF325-5		.	NUT (KF) (AP)	3		
	AN960-516		.	WASHER (KF) (AP)	3		
	99-4061	99167	.	GASKET, Shipping, Inlet (KF)	1		
	102-1153	99167	.	COVER ASSEMBLY, Shipping . (KF)	1		
<u>Usable On Code</u>							
A 024536-209-09							
B 025264-200-02							
C 024536-213-09							
D 024536-214-10							

SECTION III
NUMERICAL INDEX

Part Number	Figure and Index	Part Number	Figure and Index	Part Number	Figure and Index
AF325-4	F 6-6	02-12793-01	4-29	02-14881	4-57
AF325-5	F 6-6	02-12793-02	F 4-29	02-14882-02	6-4
AN150212	1-60	02-12793-03	F 4-29	02-14887	1-1
AN150237	1-58	02-12793-04	F 4-29	02-14892-01	1-70
AN535-00-2	1-44	02-12793-05	F 4-29	02-14912	4-56
AN814-4L	1-14	02-12826	4-33	02-14914	4-26
	4-3	02-12869-01	F 1-47	02-14964	4-14
AN960-416	4-49	02-12869-02	F 1-47	02-14999	4-5
	4-7	02-12869-03	F 1-47	02-14999-01	F 4-5
	F 6-6	02-12869-04	F 1-47	02-15000-01	4-8
		02-12869-05	F 1-47	02-15001-01	4-19
AN960-516	F 6-6				
AN960-516L	1-39	02-12869-06	F 1-47	02-15001-02	F 4-19
AN960-616L	1-53	02-12869-07	1-47	02-15001-03	F 4-19
AN960C10	4-23	02-13070	4-36	02-15010-01	4-52
KR5A-15	1-34	02-13704	4-28	02-15234	F 6-6
KR6-15	6-5	02-14125	5-19	02-15242	2-9
KR6A-15	4-67	02-14182-01	4-21	02-15243	2-6
LH3830-064	1-52	02-14183	4-24	02-15245	2-1
L246-7-6S-PF	6-6	02-14184	4-25	02-15246-01	2-4
MS134356	3-6	02-14211	4-64	02-15246-02	F 2-3
		02-14518	1-56	02-15246-03	F 2-3
MS16555-602	5-8				
	5-13	02-14528	5-22	02-15246-04	2-3
6555-631	4-41	02-14530-01	5-17	02-15279	5-4
MS16556-825	4-50	02-14533	1-64	02-15280	5-6
MS16556-840	6-3	02-14534-02	4-69	02-15288-01	5-31
MS16566-825	6-2	02-14566	4-59	02-15289-01	5-14
MS16625-4045	3-3	02-14696	1-68	02-15292-01	5-29
MS171432	4-51	02-14709-03	5-25	02-15293	5-26
MS20002C4	1-46	02-14711-01	5-9	02-15294	5-30
MS20365-1032C	4-22	02-14712-01	5-12	02-15301	1-26
MS21046C8	5-27	02-14723-02	4-1	02-15301-01	F 1-26
MS21208C5-15	6-1	02-14724-01	5-23	02-15302	1-29
MS21209F4-15	1-19	02-14731	1-7	02-15383	F 4-18
MS28774-020	5-11	02-14745-01	4-30	02-15397	1-32
MS9105-27	4-62	02-14761	4-42	02-15582	3-7
MS9105-30	4-54	02-14762	4-40	02-15584	3-4
MS9276-14	5-28	02-14781	1-18	02-15823-02	F 4-69
M305JX2014	F 5-16	02-14785	4-63	02-15824	F 4-45
	F 5-24	02-14794-01	4-45	02-15825	F 4-18
NAS620-416	F 5-2	02-14795-02	4-53	02-15826-01	F 4-56
NAS620-416L	5-2	02-14801-01	1-20	02-15827-01	F 1-47
NAS620-8	4-10	02-14808-02	1-36	02-15827-02	F 1-47
	4-32	02-14850	4-61	02-15827-03	F 1-47
No Number	1-37	02-14852	4-13	02-15827-04	F 1-47
	1-62	02-14855	4-18	02-15827-05	F 1-47
V**75AS7DA	5-16	02-14859	1-67	02-15827-06	F 1-47
	5-24	02-14875-02	1-22	02-15827-07	F 1-47

Part Number	Figure and Index	Part Number	Figure and Index	Part Number	Figure and Index
02-15828	5-7	504245	1-57	99-4318	4-44
02-15829	5-8A	702086	1-61	99-4319	4-43
02-15830-01	F 4-63	99-2198	F 6-6	99-4344	1-11
02-16113	F 1-57	99-2350	4-60	99-4345	1-13
024536-209-09	1-	99-2973-10	1-66	99-4346-112	1-8
024536-213-09	F 1-	99-2973-12	4-55	99-4346-16	2-8
024536-214-10	F 1-	99-2973-127	1-30		4-46
025264-200-02	F 1-		1-31	99-4346-221	1-12
102-1142	1-50	99-2973-13	1-65	99-4346-234	4-11
102-1149	5-20	99-2973-130	1-69	99-4346-240	4-20
102-1153	F 6-6	99-2973-142	4-16		4-65
102-1207-01	4-66	99-2973-19	1-49	99-4346-241	1-42
102-1224	4-58	99-2973-20	5-10	99-4351	4-35
102-1231-01	1-16	99-2973-21	5-15	99-4352	4-34
102-1235-02	1-33	99-2973-241	1-63	99-4368	1-51
102-1258-01	5-3	99-2973-38	4-15	99-4380	F 6-6
102-1274-02	1-72	99-2973-6	1-25	99-4381	F 6-6
	6-	99-2973-9	4-27	99-4394-07	4-9
102-1288-01	4-12	99-2975-4	1-15	99-4448	1-71
102-1302-02	1-40		4-4	99-4496	1-41
	4-	99-2975-5	1-4	99-4498	1-9
102-1302-05	F 1-40	99-2975-6	F 6-6	99-4531	2-2
102-1213	4-39				
		99-2975-8	1-2	99-4533	2-7
	F 4-	99-3371	4-68	99-4567-04	5-5
102-1302-06	F 1-40	99-3987	5-21	99-4580	1-28
	F 4-	99-3999	5-18	99-4581	1-27
102-1347-04	1-48	99-4058	F 6-6	99-4601-009	F 4-27
	5-	99-4059	F 6-6	99-4601-012	F 4-55
102-1352	4-47	99-4061	F 6-6	99-4601-016	F 2-8
102-1380	2-5	99-4186	1-35		F 4-46
102-1381	1-3	99-4188	1-45	99-4601-017	3-2
	2-	99-4190	1-38	99-4601-110	F 4-35
102-1381-01	F 1-3	99-4191	4-48	99-4601-112	F 1-8
	F 2-		4-6	99-4601-127	F 1-31
102-1478	1-5	99-4193-04	4-31	99-4601-142	F 4-16
	3-	99-4194-10	1-54	99-4601-221	F 1-12
102-1482	3-1	99-4195-06	1-10	99-4601-234	F 4-11
102-1522-01	F 1-48	99-4196-02	1-17	99-4601-240	F 4-20
	F 5-	99-4200	F 6-6		F 4-65
102-1559-02	F 4-66	99-4203-06	4-2	99-4601-241	F 1-42
102-1560	5-7	99-4221	F 6-6	99-4601-500	F 4-38
102-1561-03	F 1-40	99-4247	1-55	99-4601-501	1-71
	F 4-	99-4287	4-38	99-4602-04	F 1-15
102-1562-02	F 4-58	99-4288	4-37		F 4-4
119FW428	5-1	99-4302	1-24	99-4602-05	1-6
32-0455	F 6-6	99-4303	1-21		F 1-4
504243	1-59	99-4304	1-23	99-4630	4-17

OPERATION PROFILE

NAME <u>R.S. OLDS</u>		ALC <u>OC</u>		DATE <u>31 MAY 89</u>		RCC <u>MAT PCB</u>		SHEET <u>1</u> OF <u>4</u>																
NSN <u>96555 A</u>		WCD <u>CBY 17</u>		WCD DATE <u>88 239</u>																				
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT			TIME REQUIRED	DATA SOURCE COMMENTS											
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE			QTY.	%	HRS.								
00	MAT PCB	IN DATE	1.0	TRANSIT	32																			
				SETUP																				
				PROCESS																				
05	MAT PCB	REC	1.0	TRANSIT				BT M/F 09	1			.14												
				SETUP																				
				PROCESS																				
10	MAT PCB	ASSY	1.0	TRANSIT				BT M/F 09	1			.03												
				SETUP																				
				PROCESS																				
15	MAT PCB	ASSY	.60	TRANSIT				BT M/F 09	1			0.5	0.5	0.5	EQUIP ACT = OC #5739									
				SETUP																				
				PROCESS																				
18	MAT PCB	INSP	1.0	TRANSIT				BT M/F 09	1			1.5	1.5	1.5	~60% OF PUMPS REQUIRE RETURN WHILE ON FLOW STAND; REWORK TAKEN RETURN 1 AND 2 HOURS. ACT. CORR = OC 5739									
				SETUP																				
				PROCESS																				
				TRANSIT				BT M/F 09	1			.08	.08	.08	OLD OP 080; INSP OIL FILTER									
				SETUP																				
				PROCESS																				

OPERATING PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MAT PCB SHEET 2 OF 4

WCD CREY 17 WCD DATE 88 239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			SKILL CODE/ LEVEL	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.	QTY.		TIME REQUIRED %	HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	HRS.		
19	MAT PCB	TEST	1.0	TRANSIT											OLD OP #090 CHECK CUBE FLOW ALT EQUIP = OC 5139	
				SETUP												
				PROCESS												
20	MAT PCB	TEST	1.0	TRANSIT											INCLUDES OLD OPS # 20, 30, 40, 50, 60, & 70 ALT EQUIP = OC 5139	
				SETUP												
				PROCESS												
100	MAT PCB	INSP	1.0	TRANSIT											NOT USUALLY DONE - ANY CONDITIONS DISCOVERED IN THIS PROCEDURE WILL HAVE CAUSED PUMP TO FAIL TEST REMOVE THIS POINT	
				SETUP												
				PROCESS												
110	MAT PCB	TEST	1.0	TRANSIT											ANY INTERNAL LEAKAGE WILL BE EVIDENT IN OP #020	
				SETUP												
				PROCESS												
120	MAT PCB	ASSY	1.0	TRANSIT												
				SETUP												
				PROCESS												

OLD OR #090
CHECK LUBES
FLOW

ALT EQUIP = OC 5139

INCLUDES
OLD OPS #
20, 30, 40, 50,
60, & 70

ALT EQUIP = OC 5139

NOT USUALLY
DONE - ANY
CONDITIONS
DISCOVERED BY THE
PROCEDURE WILL
HAVE CAUSED PUMP
TO FAIL TEST BEFORE
THIS POINT

ANY INTERNAL
LEAKAGE WILL
BE EVIDENT
IN OR #020

OPERATION PROFILE

NAME <u>R.S. OLDS</u>		ALC <u>OC</u>		DATE <u>31 MAY 89</u>		RCC <u>MATPER</u>		SHEET <u>3</u> OF <u>4</u>						
PCW <u>96055 A</u>		WCD <u>CR24 17</u>		WCD DATE <u>88 239</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED	DATA SOURCE COMMENTS		
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.			EQUIPMENT CODE	QTY.
130	MAT PCB	ASSY	1.0	TRANSIT									TIME INCLUDED IN PREVIOUS OPS.	
				SETUP										
				PROCESS										
140	MAT PCB	P.W.	1.0	TRANSIT									CERTIFICATION	
				SETUP										
				PROCESS										
150	MAT PCB	PROC	1.0	TRANSIT									OIL FLUSH - NO OIL FLUSH STAND AVAILABLE SO PAUSE w/ PT. OF OIL INTO PUMP AND SPIN IMPELLER	
				SETUP										
				PROCESS										
160	MAT PCB	MOVE	1.0	TRANSIT									ON MINGROAD	
				SETUP										
				PROCESS										
170	MAT PCB	P.W.	1.0	TRANSIT										
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MAT PCB SHEET 4 OF 4

PCN 96555 A WCD CBEY 17 WCD DATE 88237

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	QTY.	%	
9999	MAT PCB	OUT DEFE	1.0	TRANSIT								
				SETUP								
				PROCESS		24						
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
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				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

FLOW PROCESS CHART

SUBJECT FUEL PUMP TEST

DATE 1 JUN 89

ITEM CODE

WCD CBEY 17

WCD DATE 88234

PCN
HON
P/M

96555A

CHART BEGINS 00 IN

CHART ENDS 9999 SEZL OUT

PREPARED BY R. S. OLDS

[illegible]

○ OPERATION

TRANSPORTATION

▽ STORAGE

D DELAY

INSPECTION

LSC-20147

"IN" DATES PROBLE

NAME _____		ALC <u>OC-ALC</u>		DATE <u>21 MAR 89</u>		RCC <u>MTPCB</u>		SHEET <u>1</u> OF <u>1</u>	
PCI <u>96555A</u>		PARENT WCD _____		PARENT WCD DATE _____					
OBSERVATION NUMBER	"II" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (HOURS)						
1	8287	8289	72						
2	8300	8300	0						
3	8347	8348	14						
4	9005	9006	1						
5	9034	9037	72						
6	9045	9045	0						
			(32)						

NOTE: "II" DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD ON DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

"OUT" DATES PROC FILE

NAME _____ ALC _____ DATE 31 MAR 199 _____		RCC _____		SHEET _____ OF _____	
PCI		PATIENT WCD		PATIENT WCD DATE	
96555A					
OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (H:M:S)	
1	8295	8295	8295	0	
2	8305	8306		7:1 "	
3	8355	8355		" 0	
4	9012	9017		1 "	
5	9041	9041		0	
6	9048	9048		0	
7				(24)	

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATION PROFILE

NAME <u>P. Hunt</u>		ALC <u>CC</u>		DATE <u>603 89</u>		RCC <u>CC</u>		SHEET <u>1</u> OF <u>4</u>			
OPERATION <u>97150 A</u>		WCD <u>CBE404</u>		WCD DATE <u>88174</u>							
OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	QTY.	
00	MATP CB	IN DATE	1.0	TRANSIT							
				SETUP							
				PROCESS							
10	MATP CB	REC	1.0	TRANSIT							REC, S/N ON, ATTACH PW
				SETUP							
				PROCESS							
20	MATP CB	DIS	1.0	TRANSIT							DIS. PUMP, DYE MARK ENDS OF GEAR TEETH.
				SETUP							
				PROCESS							
30	MATP CB	CLN		TRANSIT							CLN IN PDG80-USE WIRE BASKET
				SETUP							
				PROCESS							
40	MATP CB	PW		TRANSIT							ASSURE S/N & PW IS CORRECT
				SETUP							
				PROCESS							

OPERATION PROFILE

[illegible]

OPERATION PROFILE

NAME <u>P Hunt</u>		ALC <u>OC</u>		DATE <u>6-03-89</u>		RCC <u>OC</u>		SHEET <u>4</u> OF <u>4</u>						
PCU 97150		WCD <u>CBE404</u>		WCD DATE <u>88174</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW (HOURS)	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	INS.	EQUIPMENT CODE	QTY.		TIME REQUIRED %	INS.
170	MAPP CB	CW	1.0	TRANSIT									c/w NAOI 606-36 PAR. 13	
				SETUP										
				PROCESS										
9999	MAPP CB	OUT DATE	1.0	TRANSIT			AP09	1	100	.17	BEN402	1	100	.17
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

DISASSEMBLY/ASSEMBLY FILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>6-05-89</u>		RCC <u>MA72013</u>		SHEET <u>1</u> OF <u>2</u>	
TOP ASSEMBLY				SUBASSEMBLY			NAME REMOVED ITEM INSTALLED INTO ASSEMBLY		
ITEM NUMBER	WCO	WCO DATE	REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	ITEM NUMBER	CHLD WCO	CHLD WCO DATE		
PCN NSN PIN 97150A	CBE404	88174	20	120	PCN NSN PIN C251	CBE404S1			
PCN NSN PIN					PCN NSN PIN C283				
PCN NSN PIN					PCN NSN PIN 102-230				
PCN NSN PIN					PCN NSN PIN 02-15767				
PCN NSN PIN					PCN NSN PIN 02-12707				
PCN NSN PIN					PCN NSN PIN 02-15790				
PCN NSN PIN					PCN NSN PIN 02-12272				
PCN NSN PIN					PCN NSN PIN 02-15763				
PCN NSN PIN					PCN NSN PIN 02-15764				
PCN NSN PIN					PCN NSN PIN 02-12705				
PCN NSN PIN					PCN NSN PIN 02-12704				
PCN NSN PIN					PCN NSN PIN 02-11925				

LSC-20WJ5A

NAME Pfunt

ALC.

60

DATE _____

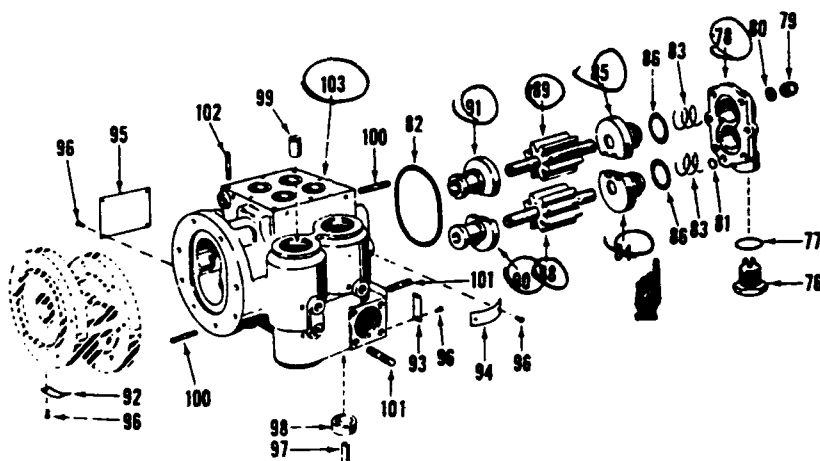
DATE 68-05-89

MA: Dr R.

SHEET 2 of 2

[illegible]

LSC-20XVSA



A-20527

Figure 2. Part Number 022994 Series Dual Fuel Pump Assembly Exploded View (Sheet 3 of 3)

FIG & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7	DESCRIPTION	UNIT PER ASSY	USABLE ON CODE
2-					
-76	AN814-12DL	.	PLUG (KC)	1	
-77	MS29512-12	.	GASKET	1	
-78	02-11925	.	COVER, Rear	1	
			(ATTACHING PARTS)		
-79	AN310-6	.	NUT (KC)	6	
-80	AN960-616	.	WASHER (KC)	6	

-81	MS29513-112	.	PACKING, Preformed	1	
-82	MS29513-235	.	PACKING, Preformed	1	
-83	02-650	.	SPRING, Bearing (KD)	2	
-84	02-13098	.	BEARING, Rear Cover Driven Gear	1	ADEFGH
					LJK
					BC
-85	02-12282	.	BEARING, Rear Cover Driven Gear	1	ADEFGH
	02-13097	.	BEARING, Rear Cover Drive Gear	1	LJK
					BC
-86	02-12281	.	BEARING, Rear Cover Drive Gear	1	
-87	MS29513-126	.	PACKING, Preformed	2	
-88	902-031	.	GEARS (Matched set)	1	ALJK
-89	02-12274	.	GEAR, Driven	1	
	02-13926	.	GEAR, Drive	1	ALJK
	02-12273	.	GEAR, Drive	1	BCDEFGH
	902-029	.	BEARINGS, Body (Matched set)	1	ALJK
-90	02-13096	.	BEARING, Body Driven Gear	1	ADEFGHI
					JK
					BC
-91	02-12280	.	BEARING, Body Driven Gear	1	ADEFGHI
	02-13095	.	BEARING, Body Drive Gear	1	JK
					BC
	02-12279	.	BEARING, Body Drive Gear	1	
-92	99-520	.	PLATE, Rotation Name	1	
-93	316-13	.	PLATE, Inlet Name	1	
-94	172-32BN	.	PLATE, Name	1	
-95	02-580	.	PLATE, Pressure Port Identification	1	
			(ATTACHING PARTS FOR PLATES)		
-96	AN535-00-2	.	SCREW (KD)	10	

-97	102-515	.	BODY ASSY	1	
-98	02-563	.	GUIDE, Valve	1	
-99	99-1137	.	SEAT, Valve (KD)	1	
-99	02-1209	.	GUIDE, Valve	1	
-100	99-378	.	STUD	14	
	99-1698-01	.	STUD (0.003 inch oversize)	AR	
			(replacement for 99-378)		
	99-1698-02	.	STUD (0.006 inch oversize)	AR	
			(replacement for 99-378)		
-101	99-1136	.	STUD	8	
	99-1606-01	.	STUD (0.003 inch oversize)	AR	
			(replacement for 99-1136)		
	99-1601-02	.	STUD (0.006 inch oversize)	AR	
			(replacement for 99-1136)		
-102	99-2553	.	STUD	8	
	99-2553-01	.	STUD (0.003 inch oversize)	AR	
			(replacement for 99-2553)		
	99-2553-02	.	STUD (0.006 inch oversize)	AR	
			(replacement for 99-2553)		
-103	02-10993	.	BODY	1	
	102-516	.	KIT, Front Cover Shipping Block (KD, KF)	1	
	102-176	.	KIT, Inlet Port Shipping Block (KD)	1	
	102-177	.	KIT, Fuel Bypass Return Port Shipping	1	
			Block (KD)		
	102-178	.	KIT, Discharge Port Shipping Block (KD)	1	
	32-0534	.	PARTS KIT, Pump, Overhaul (D)	1	AHLJK
	32-0026	.	PARTS KIT, Pump, Overhaul	1	B
	32-0025	.	PARTS KIT, Pump Cure Date	1	B
	32-0373	.	PARTS KIT, Pump, Field (F)	1	J
	32-0377	.	PARTS KIT, Pump, Overhaul (D)	1	J

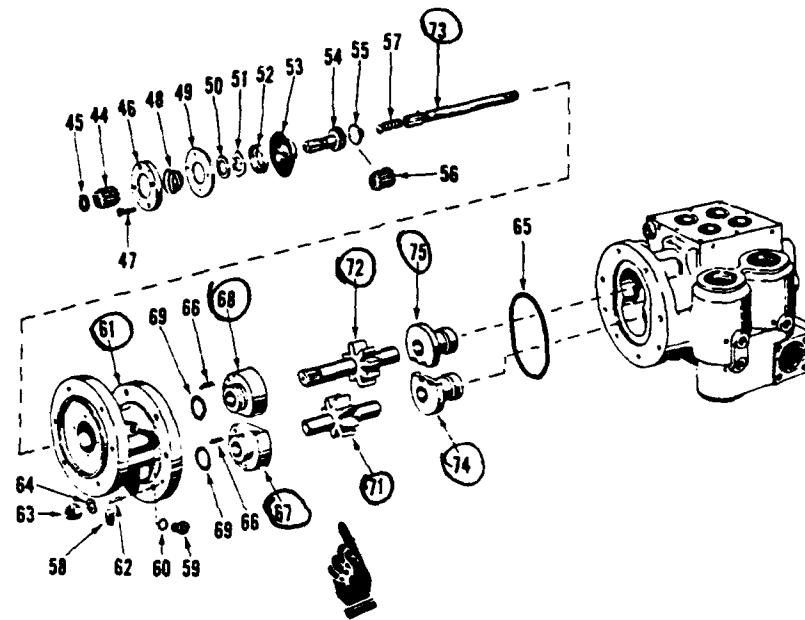
FIG. & EX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
2-70	902-151	. GEARS (Matched set)	1	A
	902-032	. GEARS (Matched set)	1	LJK
(72)	02-12272	. . GEAR, Drive	1	A
	02-15763	. . GEAR, Drive	1	BCDEFGH
	02-12283	. . GEAR, Drive	1	LJK
	02-13924	. . GEAR, Drive	1	A
(73)	02-15764	. SHAFT, Drive	1	BCDEFGH
	02-10969	. SHAFT, Drive	1	LJK
	02-13925	. SHAFT, Drive	1	ALJK
	902-030	. BEARINGS, Body (Matched set).	1	ACDEFGH
(74)	02-12705	. . BEARING, Body Driven Gear	1	LJK
	02-12278	. . BEARING, Body Driven Gear	1	B
(75)	02-12704	. . BEARING, Body Drive Gear	1	ACDEFGH
	02-12277	. . BEARING, Body Drive Gear	1	LJK
				B

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
2-					
-44	02-561		. ADAPTER	1	BCDE
	02-13738		. ADAPTER	1	FGHLJK
			(ATTACHING PARTS)		
-45	MS901321		. RING (KD)	1	BCDEFG

-46	02-13460		. PLATE, Thrust	1	HLJK
	02-81		. PLATE, Thrust (KC)	1	A
	02-12361		. PLATE, Thrust (KC)	1	BC
			(ATTACHING PARTS)		DEFGHI
					JK
-47	782-22		. SCREW, Use 4 units with usable on codes . . .	6	A
			D, E, F, G, H, I, J, K (KC)		
	AN505-10-10		. SCREW (KC)	4	BC

-48	99-1924		. SPRING	1	A
	99-227		. SPRING, Seal	1	BCDEFG
					HLJK
-49	02-14016		. STOP, Seal	1	A
	02-1206		. STOP, Seal	1	BC
	02-12360		. STOP, Seal	1	DEFGHI
					JK
-50	99-1925		. WASHER, Spring	1	A
	99-276		. WASHER, Spring (KD)	1	BCDEFG
					HLJK
-51	02-14015		. WASHER Wobble	1	A
	02-1207		. WASHER, Tab	1	BCDEFG
					HLJK
-52	02-11027		. GUIDE, Diaphragm	1	A
	739-53		. GUIDE, Diaphragm	1	BCDEFG
					HLJK
-53	102-974		. SEAL ASSY, Diaphragm	1	A
	102-388		. SEAL ASSY, Diaphragm (KC)	1	BCD
	102-728		. SEAL ASSY, Diaphragm	1	E
	102-417		. SEAL ASSY, Diaphragm (KC)	1	FGHLJK
-54	02-15765		. COUPLING	1	A
	02-12148		. COUPLING	1	BCD
	02-12703		. COUPLING	1	EFG
	02-13740		. COUPLING	1	HLJK
-55	02-13731		. SPACER, Coupling	AR	JK
	02-14041		. SPACER, Coupling	AR	JK
-56	02-15766		. ADAPTER	1	A
-57	99-3781		. SPRING	1	A
	99-1919		. SPRING (KD)	1	BCDEFG
					HLJK
-58	AN913-1S		. PLUG (KD)	1	BCDEFG
					HLJK
-59	AN814-4L		. PLUG (KC)	2	
-60	MS29512-4		. GASKET	2	
-61	02-15767		. COVER, Front	1	A
	02-10907		. COVER, Front	1	BCDEFG
					HLJ
	02-14365		. COVER, Front	1	K
			(ATTACHING PARTS)		
-62	99-1230		. PIN, Taper (KC)	2	
-63	AN310-6		. NUT (KC)	8	
-64	AN960-616		. WASHER (KC)	8	

-65	MS29513-241		. PACKING, Preformed	1	
-66	764-6C		. SPRING, Bearing (KD)	14	
-67	02-12707		. BEARING, Front Cover Driven Gear	1	ACDEFG
					HLJK
-68	02-11787		. BEARING, Front Cover Driven Gear	1	B
	02-15790		. BEARING, Front Cover Drive Gear	1	A
	02-11786				B
	02-12706		. BEARING, Front Cover Drive Gear	1	CDEFGH
	02-15790		. BEARING, Front Cover Drive Gear	1	IJK
-69	MS29513-131		. PACKING, Preformed	2	

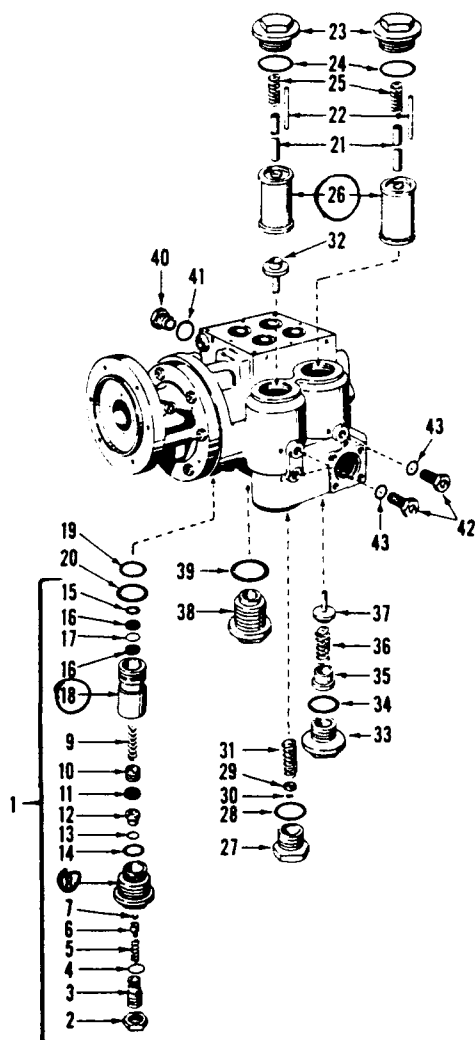


A-20526

Figure 2. Part Number 022994 Series Dual Fuel Pump Assembly Exploded View (Sheet 2 of 3)

FIG. & INDEX NO.	PART NUMBER	1 2 3 4 5 6 7 DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
2-	022994-024-08	PUMP ASSY, Dual Gear-Type Fuel	1	A
	022994-020-01	PUMP ASSY, Dual Gear-Type Fuel	1	B
	022994-020-02	PUMP ASSY, Dual Gear-Type Fuel	1	C
	022994-020-3B	PUMP ASSY, Dual Gear-Type Fuel	1	D
	022994-020-04	PUMP ASSY, Dual Gear-Type Fuel	1	E
	022994-021-04	PUMP ASSY, Dual Gear-Type Fuel	1	F
	022994-021-05	PUMP ASSY, Dual Gear-Type Fuel	1	G
	022994-022-05	PUMP ASSY, Dual Gear-Type Fuel	1	H
	022994-022-06	PUMP ASSY, Dual Gear-Type Fuel	1	I
	022994-022-07	PUMP ASSY, Dual Gear-Type Fuel	1	J
	022994-024-07	PUMP ASSY, Dual Gear-Type Fuel	1	K
-1	C103-03	VALVE ASSY, Pressure Relief (MFD by 98939) (02-13670)	1	AGHLJK
	C103-01	VALVE ASSY, Pressure Relief (MFD by 98939) (02-11021)	1	BC
	C103-02	VALVE ASSY, Pressure Relief (MFD by 98939) (02-12889)	1	DEF
-2	A21117	.. NUT, Lock (98939)	1	
-3	C252	.. SCREW, Adjusting (98939)	1	
-4	MS29513-112	.. PACKING, Preformed (98939)	1	
-5	A331R007	.. SPRING (98939) (KD)	1	
-6	C282	.. END, Spring (98939)	1	
-7	A21137	.. BALL (98939) (KD)	1	
-8	C251	.. HOUSING (98939)	1	
-9	C255	.. SPRING, Valve (98939) (KD)	1	
-10	A211R020	.. SCREW, Lock (98939)	1	AGHLJK
	C134	.. SCREW, Lock (98939)	1	BC
	A211R007	.. SCREW, Lock (98939)	1	DEF
-11	A2073	.. SCREEN SUB-ASSEMBLY Filter (98939) (KD)	1	ADEFGH
-12	A441R0147	.. SEAT (98939) (KD)	1	LJK ADEFGH LJK BC
	C154	.. SEAT (98939) (KD)	1	
-13	C151	.. GASKET (98939) (KD)	1	
-14	MS29513-114	.. PACKING, Preformed (98939)	1	
-15	A2047	.. RING, Retaining (98939) (KD)	1	
-16	A2044	.. SCREEN, Back-up (98939) (KD)	1	
-17	A2045	.. SCREEN, Filter (98939) (KD)	1	
-18	C283	.. PISTON AND SLEEVE ASSY (98939)	1	
	*C281	.. RIVET (98939)	1	
	*C254	.. PISTON (98939)	1	
	*C253	.. SLEEVE (98939)	1	
-19	MS29513-116	.. PACKING, Preformed	1	
-20	MS29512-16	.. GASKET	1	
	102-225	.. PLUG ASSY, Filter	2	BC
-21	02-1214	.. SHAFT, Filter	1	BC
-22	02-10942	.. PIN	1	BC
-23	02-10935	.. PLUG, Filter	1	
-24	MS29512-28	.. GASKET	2	
-25	99-1135	.. SPRING, Filter (KD)	2	BC
-26	102-230	.. FILTER ASSEMBLY	2	BC
-27	02-1215	.. PLUG, Inlet Check Valve (KD)	1	
-28	MS29512-10	.. GASKET	1	
-29	02-1213	.. RETAINER, Spring (KD) (ATTACHING PARTS)	1	
-30	99-1451	.. PIN (KD)	1	
-31	99-1184	.. SPRING, Inlet Check Valve (KD)	1	
-32	02-1212	.. VALVE, Inlet Check	1	
-33	02-10375	.. RETAINER, Pressure Regulating Valve	1	
-34	MS29512-16	.. GASKET Retainer	1	
-35	02-10374	.. STOP, Valve	1	
-36	99-1666	.. SPRING, Valve (KD)	1	
-37	02-564	.. VALVE, Secondary Pressure Regulating	1	
-38	02-11020	.. PLUG	1	
-39	MS29512-16	.. GASKET	1	
-40	AN814-10L	.. PLUG (KC)	2	
-41	MS29512-10	.. GASKET	2	
-42	AN814-4L	.. PLUG, Use 5 units with usable on code K	6	
-43	MS29512-4	.. GASKET	6	

*Not procurable as a separate part



A-20525

Figure 2. Part Number 022994 Series Dual Fuel Pump Assembly Exploded View (Sheet 1 of 3)

OPERATION PROFILE

NAME <u>PHUT</u>		ALC <u>OC</u>		DATE <u>060389</u>		RCC <u>MAIPCB</u>		SHEET <u>1</u> OF <u>3</u>			
PCN <u>97150 A</u>		WCD <u>CBE 4TY</u>		WCD DATE <u>88174</u>							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAIPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE	
00	MATP CB	IN DATE	1.0	TRANSIT	24						
				SETUP							
				PROCESS							
010	MATP CB	TEST	1.0	TRANSIT							INST. PUMP ONCE FLOW Bench.
				SETUP							
				PROCESS							
020	MATP CB	TEST	1.0	TRANSIT							CALIBRATION RUN.
				SETUP							
				PROCESS							
030	MATP CB	TEST	1.0	TRANSIT							ENDURANCE RUN
				SETUP							
				PROCESS							
031	MATP CB	TEST	1	TRANSIT							10% OF TIRMS ARE MATP DOC'D.
				SETUP							
				PROCESS							

OPERATION PROFILE

NAME <u>P HUNT</u>		ALC <u>OC</u>		DATE <u>060389</u>		RCC <u>MATP CB</u>		SHEET <u>2</u> OF <u>3</u>					
PCN <u>97150</u>		WCD <u>CB E 474</u>		WCD DATE <u>88774</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	% HRS.	EQUIPMENT CODE	QTY.	% HRS.		
040	MATP CB	TEST	1.0	TRANSIT									SURGE TEST OR 060389
				SETUP									
				PROCESS									
050	MATP CB	TEST	1.0	TRANSIT									SURGE TEST HIGH PRESSURE OR 060389
				SETUP									
				PROCESS									
060	MATP CB	TEST	1.0	TRANSIT									MISC. FLOW RATES OR 060389
				SETUP									
				PROCESS									
070	MATP CB	TEST	1.0	TRANSIT									INSTALL DUMP RELIEF VALVE OR 060389
				SETUP									
				PROCESS									
110	MATP CB	TEST	1.0	TRANSIT									PUMP CALIB. MAN OR 060389
				SETUP									
				PROCESS									

OPERATION PROFILE

[illegible]

SUBJECT DUAL fuel PUMP FLOW PROCESS CHART

DATE 6-03-89

WCD CBE 414 WCD DATE 88174

CHART BEGINS 010 INSTALL PUMP ON FLOW BENCH

CHART ENDS: 140 INST. SHIPPING BLOCKS + ^{AVOS} PREPARED BY P HUNT

[illegible]

○ OPERATION
◇ TRANSPORTATION

▽ STORAGE
D DELAY

☐ INSPECTION

LSC-20147

"IN" DATES PROFILE

NAME _____ ALC <u>OC-ALC</u> DATE <u>31 MAY 89</u> RCC <u>MTPCB</u> SHEET <u>1</u> OF <u>1</u>				
PCR INSI PRI	PARENT WCD	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (HRS)
971504				
1	8278	8377	8377	24
2	8334	8335	8335	24
3	9010	9009	9009	24
4	9003	9034	9034	24
5	9080	9031	9031	24
6	9034	9075	9075	24
7	9103	" 13	" 13	24
8	9120	9123	9123	24
9	9124	9130	9130	24
10	9137	9138	9138	24
				(24)

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING EMPLOYERS III BLOCK 5 OF WCD OR DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

"OUT" DATES PROC. LE

NAME _____		ALC <u>OC-ALL</u>	DATE <u>31 MAY 89</u>	ICC <u>MT-PCB</u>	SHEET <u>1</u> OF <u>1</u>
PCII	HSII	PHI	PARENT WCD DATE <u>700701</u>		
OBSERVATION NUMBER			LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULING SELL DATE)	TIME (HRS)
1			8228		0
2			8242		0
3			9060		0
4			9062		0
5			9090		0
6			9102		0
7			9110		0
8			9122		0
9			9122		0
10			9146		0
11					0

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE ICC.

OPERATION PROFILE

NAME R. Harris / R.S. Olds ALC OC DATE 30 MAY 89 RCC MAT PCB SHEET 1 OF 5

PCN 97178 A WCD CBE 405 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	QTY.	%	HRS.	
00	MAT PCB	IN	1.0	TRANSIT										
				SETUP										
				PROCESS										
5	MAT PCB	REC	1.0	TRANSIT										RECEIVE PUMP FROM ENGINE LINE AND STOCK IN BIN
				SETUP										
				PROCESS			BP 09	1		.03				
10	MAT PCB	REC	1.0	TRANSIT										
				SETUP										
				PROCESS			BP 09	1		.03	02 80410	1	.03	
15	MAT PCB	CLN	.05	TRANSIT										5% OF ALL PUMPS ARE MATROC.; ARE CLEANED AND SENT TO TEST (CBE 4TS)
				SETUP										
				PROCESS			BP 09	1		1.0				
20	MAT PCB	DIS	.95	TRANSIT										
				SETUP										
				PROCESS			BP 09	1		1.5	80410	1	1.5	

OPERATION PROFILE

NAME <u>R. HARRIS / R.S. OLDS</u> ALC <u>OC</u> DATE <u>30 MAY 89</u> RCC <u>MATPCB</u> SHEET <u>2</u> OF <u>5</u>		WCD <u>CRE 405</u> WCD DATE <u>88174</u>		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED				
					%	HRS.			%	HRS.			%	HRS.			
30	MAT PCB	CLN	.95	TRANSIT											3 PD-680 MACHINES ALL ID #OC 1178 (2 ALITATED TANKS + 1 JERRY BOOTH)		
				SETUP													
				PROCESS	1.2		BP 09	1			OC 1178	1					
40	MAT PCB	INSP	.95	TRANSIT													
				SETUP													
				PROCESS			BP 09	1		.25	BP 09	1		.25			
45	MAT PCM	MACH	.02	TRANSIT													
				SETUP													
				PROCESS													
50	MAT PCB	INSP	.95	TRANSIT												TIME INCLUDED IN OP 40	
				SETUP													
				PROCESS													
60	MAT PIN	PROC.	.10	TRANSIT												WELDING / SOLDERING OF VALVE "B" PART	
				SETUP													
				PROCESS													

OPERATION PROFILE

NAME R. HARRIS / R.S. ODU ALC OC DATE 30 MAY 89 RCC MAT PCB SHEET 3 OF 5

WCD CBE 405 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	
70	MAT PCB			TRANSIT							MECHANIC INDICATED HE DOES NOT NEED TO CALL FOR FLUORESCENT PENETRANT INSPECTION
				SETUP							
				PROCESS							
80	MAT PCB	REPL	.98	TRANSIT							OLD 80(A) MECHANIC IDENTIFIED PART TO BE SCRAPED
				SETUP							
				PROCESS			BP 09	1	.17	1	
82	MAT PCB	P.W.	.98	TRANSIT							OLD 80(E)
				SETUP							
				PROCESS			BP 09	1	.25	1	
84	MAT PCB	PROC	.75	TRANSIT							OLD 80(C) HAND LAP SHAFT AT NECESSARY
				SETUP							
				PROCESS			BP 09	1	.04	1	
90	MAT PCB	ASSY	.98	TRANSIT							REASSEMBLY OF PUMP - INCLUDE 1 IN HAND LINE BACKST CLEANING
				SETUP							
				PROCESS			BP 09	1	4.5	1	

OPERATION PROFILE

NAME R. HARRIS / R.S. ELDS ALC OC DATE 30 MAY 89 RCC MAT PCB SHEET 4 OF 5

PCN 97178 A WCD CBE 405 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT			DATA SOURCE COMMENTS		
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.
95	MAT PCB	ASSY	.98	TRANSIT									OLD OP 105		
				SETUP											
				PROCESS			BP 09	1		.17	80410	1			.17
100	MAT PCB	ASSY	.98	TRANSIT											
				SETUP											
				PROCESS			BP 09	1		.25	80410	1			.25
110	MAT PCB	P.W.	.98	TRANSIT									INCLUDE OP 120		
				SETUP											
				PROCESS			BP 09	1		.03	80410	1			.03
130	MAT PCB	TEST	.98	TRANSIT									OPS ON WCD CBE 475 ARE DONE HERE		
				SETUP	20	48									
				PROCESS	80	24									
140	MAT PCB	P.W.	.98	TRANSIT											
				SETUP											
				PROCESS			BP 09	1		.03	80410	1			.03

OPERATION PROFILE

NAME R. Harris Jr. S. Olds ALC OC DATE 30 MAY 89 RCC MAT PCB SHEET 5 OF 5

PCN 97178A WCD CBE 405 WCD DATE 88174

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	QTY.	%		HRS.
150	MAT PCB	ASY	.98	TRANSIT										
				SETUP										
				PROCESS										
160	MAT PCB	MOVE MOVE	.98	TRANSIT									MOVE PUMP TO SELL OUT (INCL. OLD OP 170)	
				SETUP										
				PROCESS										
9999	MAT PCB	OUT		TRANSIT									SELL DATE	
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

FLOW PROCESS CHART

SUBJECT

DATE _____

5/31/89

ITEM CODE

五

NEW

PM

WCD CBE 425

WCD DATE 88124

~~X~~ 92178A

CHART BEGINS

005

CHART ENDS

160

PREPARED BY *R HARRIS*

[illegible]

○ OPERATION

TRANSPORTATION

▽ STORAGE

D DELAY

☐ INSPECTION

OPERATION PROFILE

NAME <u>R.S. OLDS</u>		ALC <u>OC</u>		DATE <u>30 MAY 89</u>		RCC <u>MAT PCB</u>		SHEET <u>1</u> OF <u>3</u>					
PCH HSN PIN <u>97178 A</u>		WCD <u>CBE 475</u>		WCD DATE <u>88174</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %
00	MAT PCB	IN	1.0	TRANSIT									
				SETUP									
				PROCESS									
5	MAT PCB	PREP ASSY REC	1.0	TRANSIT									
				SETUP									
				PROCESS									
10	MAT PCB	ASSY	1.0	TRANSIT									
				SETUP									
				PROCESS									
20	MAT PCB	TEST	1.0	TRANSIT									
				SETUP									
				PROCESS									
30	MAT PCB	TEST	1.0	TRANSIT									
				SETUP									
				PROCESS									

5-10% NEED
TRIPLE SHOOTING
ON FLOW
BENCH
(15-30 min.)
MATROC = 5%
OF TOTAL

9530 - 50
INCLUDED IN
TIME FOR
OP 20

OPERATION PROFILE

NAME <u>R.S.O.C.D.S</u>		ALC <u>OC</u>		DATE <u>30 MAY 89</u>		RCC <u>MAT PCB</u>		SHEET <u>2</u> OF <u>3</u>							
PCN <u>9178A</u>		WCD <u>CBE 475</u>		WCD DATE <u>88174</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT			TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE				QTY.
60	MAT PCB	INSP	1.0	TRANSIT											
				SETUP											
				PROCESS											
70	MAT PCB	TEST	1.0	TRANSIT											
				SETUP											
				PROCESS											
130	MAT PCB	P.W.	1.0	TRANSIT											
				SETUP											
				PROCESS											
140	MAT PCB	PROC	1.0	TRANSIT											
				SETUP											
				PROCESS											
145	MAT PCB	P.W.	1.0	TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 30 MAY 89 RCC MATPCB SHEET 3 OF 3

PCN _____															NSN _____															PIN _____															WCD _____															WCD DATE _____														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS																																																										
					%	HRS.		QTY.	%	HRS.	%			HRS.																																																												
150	MAT PCB	ASSY	1.0	TRANSIT													TIME INCL. IN 00140																																																									
				SETUP																																																																						
				PROCESS																																																																						
170	MAT PCB	MOVE	1.0	TRANSIT																																																																						
				SETUP																																																																						
				PROCESS																																																																						
9999	"	OUT	1.0	TRANSIT					BI OA 1																																																																	
		IN/E		SETUP																																																																						
				PROCESS																																																																						
				TRANSIT																																																																						
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				TRANSIT																																																																						
				SETUP																																																																						
				PROCESS																																																																						

TIME INCL.
IN 00170

N/A

BI OA

.08

32

FLOW PROCESS CHART

SUBJECT

DATE 5/3/89

ITEM CODE	
PCN	<input type="checkbox"/>
N&N.	<input type="checkbox"/>
P/M	<input type="checkbox"/>

WCD CBE 475 WCD DATE 88/74

WCD DATE 88/74

CHART BEGINS

CHART ENDS

PREPARED BY R HARRIS

[illegible]

○ OPERATION

TRANSPORTATION

▽ STORAGE

D DELAY

☐ INSPECTION

SECTION II
GROUP ASSEMBLY PARTS LIST

FIG. & INDEX NO.	PART NUMBER	1	2	3	4	5	6	7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS											
2-1-	9450-A14	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	A
2-1-	9450-A15	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	B
2-1-	9450-A16	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	C
2-1-	9450-A17	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	D
2-1-	9450-A18	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	E
2-1-	9450-A19	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	F
2-1-	9450-A20	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	G
2-1-	9450-A21	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	H
2-1-	9450-A22	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	I
2-1-	9450-A23	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	J
2-1-	9450-A24	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	K
2-1-	9450-A25	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	L
2-1-	9484-A19	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	M
2-1-	9484-A20	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	N
2-1-	9484-A21	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	O
2-1-	9484-A22	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	P
2-1-	9484-A23	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	Q
2-1-	9484-A24	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	R
2-1-	9484-A25	PUMP ASSEMBLY, FUEL, TWO-STAGE (Parts kits . . . available)								1	S
2-1-	28963-4	. PLUG, Straight, threaded								3	
-2	46675	. PLUG, Yellow anodized, straight threaded								2	
-3	MS29512-04	. PACKING, Preformed (KC)								5	A,ZZ, M,N

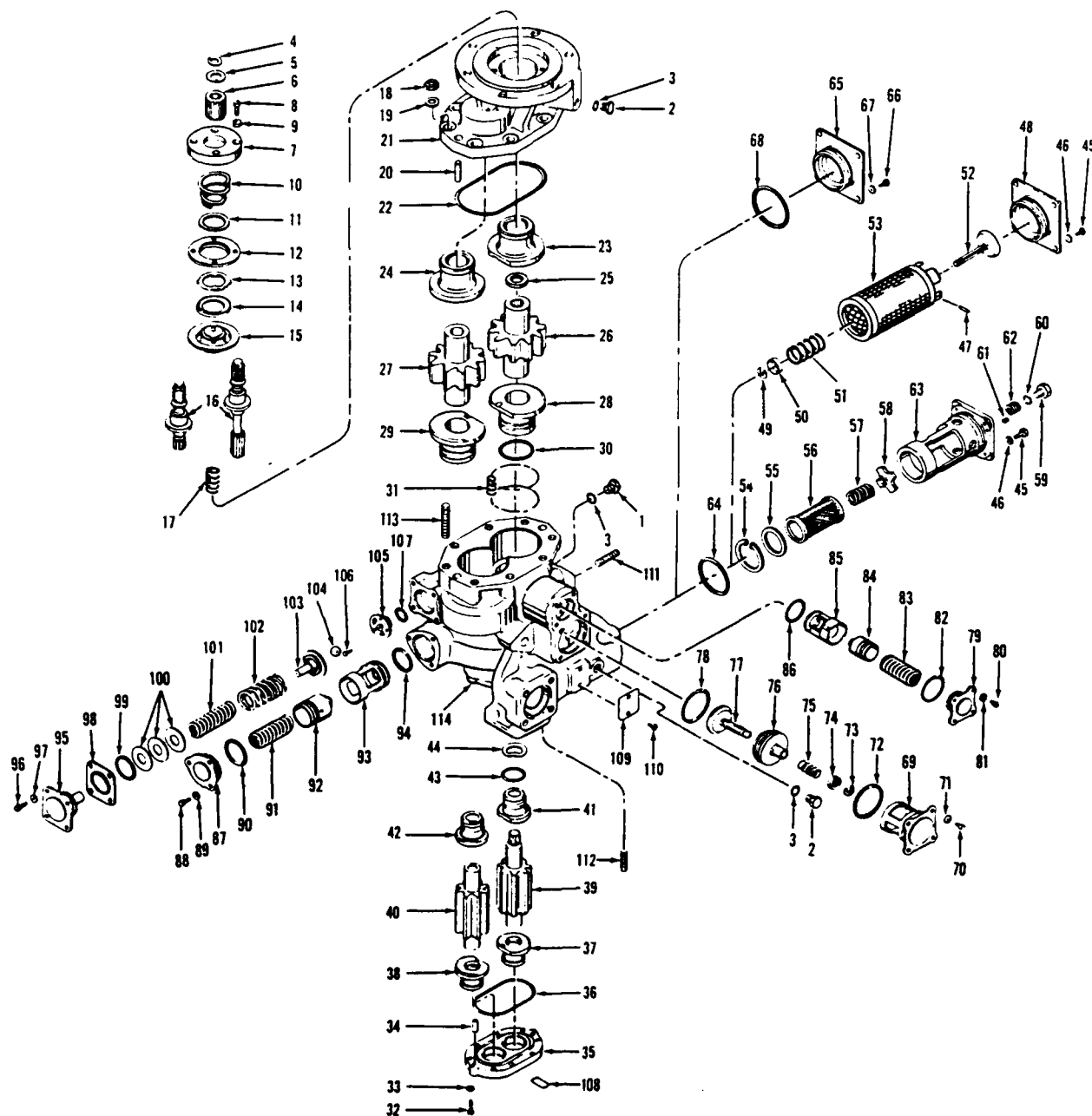


Figure 2-1. Models 9450 and 9484 Two-Stage Fuel Pumps

FIG. & INDEX NO.	PART NUMBER	1	2	3	4	5	6	7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)											
2-1-3	MS9020-04	PACKING, Preformed	5	YY,O, WW
2-1-	74681	FLANGE ASSEMBLY, Complete	1	A
2-1-	76446	FLANGE ASSEMBLY, Complete	1	ZZ,YY, XX,WW
-4	5101-46W	RING, Retaining (79136) (26286).	1	A
-4	76444	RING, Retaining	1	ZZ,YY, XX,WW
-5	27151	WASHER, Flat	1	A
-5	76443	SHIM	1	A
-6	73937	SPLINE, Main drive shaft	1	A,B,C, D,E,F M
-6	82561	SPLINE, Main drive shaft	1	G,YY,N, O,WW
-7	23929	COVER, Drive shaft	1	
(ATTACHING PARTS)											
-8	AN500-10-10	SCREW, Machine	4	
-9	12287	CUP, Locking	4	
-----*											
-10	24150	SPRING, Conical	1	
-11	23939	WASHER, Flat	1	
-12	47149	PLATE, Seal	1	
-13	48158	WASHER, Key, universal	1	
-14	47167	RING, Diaphragm	1	
-15	73909	SEAL ASSEMBLY, Diaphragm	1	
-16	74680	SHAFT, Main drive	1	A,B,C, D,E,F, M
-16	81375	SHAFT, Main drive		G,YY,N, O,WW
-17	23976	SPRING, Helical compression	1	
2-1-	23754	FLANGE AND DOWEL ASSEMBLY	1	
(ATTACHING PARTS)											
-18	23866	NUT, Plain hexagon	8	
-19	AN960-616	WASHER, Flat	8	
-----*-----											
-20	22609	PIN, Locating	2	
-21	23501	FLANGE	1	
-22	MS29513-243	PACKING, Preformed	1	A,ZZ, M,N
-22	MS9021-243	PACKING, Preformed	1	YY,O, WW
2-1-	74549	BEARING ASSEMBLY, Driving and driven	1	A,B,C
2-1-	78903	BEARING ASSEMBLY, Driving and driven	1	D,E,F, G,H,I, XX,P
2-1-	71625	BEARING ASSEMBLY, Driving and driven	1	J,K,Q, R
2-1-	86089	BEARING ASSEMBLY, Driving and driven	1	L,S

FIG. & DEX ..O.	PART NUMBER	1	2	3	4	5	6	7	DESCRIPTION	UNITS PER ASSY	USABLE CN CODE
MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)											
2-1-23	*74548	BEARING, Driving, main outer	1	A,B,C
-23	*78721	BEARING, Driving, main outer	1	D,E,F, G,H,I, XX,P
-23	*71623	BEARING, Driving, main outer	1	J,K,Q, R
-23	*86090	BEARING, Driving, main outer	1	L,S
-24	*74547	BEARING, Driven, main outer	1	A,B,C
-24	*78720	BEARING, Driven, main outer	1	D,E,F, G,H,I, XX,P
-24	*71620	BEARING, Driven, main outer	1	J,K,Q, R
-24	*86091	BEARING, Driven, main outer	1	L,S
-25	72844-010	SPACER, Splined, 0.010 in. thk	AR	
-25	72844-020	SPACER, Splined, 0.020 in. thk	AR	
-25	72844-030	SPACER, Splined, 0.030 in. thk	AR	
-25	72844-040	SPACER, Splined, 0.040 in. thk	AR	
-25	72844-050	SPACER, Splined, 0.050 in. thk	AR	
2-1-	75234	GEAR ASSEMBLY, Main driving and driven	1	A,B,C, D,E
2-1-	76489	GEAR ASSEMBLY, Main driving and driven	1	F,G,YY, XX,WW
-26	75235	GEAR, Main driving	1	A,B,C, D,E
-26	76488	GEAR, Main driving	1	F,G,YY, XX,WW
-27	24922	GEAR, Main driven	1	A,B,C, D,E
-27	76488	GEAR, Main driven	1	F,G,YY, XX,WW
-28	74550	BEARING, Driving, main inner	1	A,B,C
-28	78722	BEARING, Driving, main inner	1	D,E,F, G,H,I, XX,P
-28	71704	BEARING, Driving, main inner	1	J,K,Q, R
-28	86092	BEARING, Driving, main inner	1	L,S
-29	74551	BEARING, Driven, main inner	1	A,B,C
-29	78723	BEARING, Driven, main inner	1	D,E,F, G,H,I, XX,P
-29	71705	BEARING, Driven, main inner	1	J,K,Q, R
-29	86093	BEARING, Driven, main inner	1	L,S
-30	MS29513-127	PACKING, Preformed	2	
-31	74151	SPRING, Helical compression	14	
2-1-	23507	COVER ASSEMBLY	1	
(ATTACHING PARTS)											
-32	15050	SCREW, Socket head cap	8	
-33	2463	WASHER, Flat	8	
-----*											
-34	22609	PIN, Straight headless	2	
-35	23506	COVER	1	

ot procurable separately; order NHA.

FIG. & INDEX NO.	PART NUMBER	1	2	3	4	5	6	7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)											
2-1-36	MS29513-231	PACKING, Preformed	1	A,ZZ, M,N
-36	MS9021-231	PACKING, Preformed	1	YY,O,WW
2-1-	71624	BEARING ASSEMBLY, Driving and driven	1	
-37	*71618	BEARING, Driving, outer	1	
-38	*71617	BEARING, Driven, outer	1	
2-1-	75446	GEAR SET, Driving and driven, boost	1	
-39	75447	GEAR, Driving, boost	1	
-40	23517	GEAR, Driven, boost	1	
-41	71616	BEARING, Driving, inner	1	
-42	71619	BEARING, Driven, inner	1	
-43	MS29513-119	PACKING, Preformed	2	
-44	23512	WASHER, Spring	2	
2-1-	74876	FILTER ASSEMBLY, Complete	1	A,B,C
2-1-	71553	STRAINER ASSEMBLY, Fuel	1	D,E,F,G YY
(ATTACHING PARTS)											
-45	14862	SCREW, Socket head cap	4	A,B,C
-45	MS20074-03-04	BOLT, Machine	4	D,E,F,G, YY
-46	AN960-10L	WASHER, Flat	4	A,ZZ,YY
-47	74986	PIN, Spring	2	A,B,C
-48	74878	COVER, Filter	1	A,B,C
-49	26815	CLIP, Spring retainer	1	A,B,C
-50	23769	WASHER, Cup	1	A,B,C
-51	48054	SPRING, Helical compression	1	A,B,C
-52	23509	VALVE	1	A,B,C
-53	74877	FILTER AND VALVE SEAT ASSEMBLY	1	A,B,C
-54	5000-181W	RING, Retaining (79136) (28955-34)	1	D,E,F,G, YY
-55	71559	WASHER, Thrust	1	D,E,F,G, YY
-56	71558	STRAINER ELEMENT, Fuel	1	D,E,F,G, YY
-57	71557	SPRING, Helical compression	1	D,E,F,G, YY
-58	71556	SEAT, Spring	1	D,E,F,G, YY
-59	MS9015-04	PLUG, Machine thread	1	D,E,F,G, YY
-60	MS29513-015	PACKING, Preformed	1	D,E,F,G
-60	MS9021-015	PACKING, Preformed	1	YY
2-1-	71554	STRAINER ASSEMBLY, Body and inserts	1	D,E,F,G, YY
-61	MS122080	INSERT, Screw thread	2	D,E,F,G, YY
-62	MS124659	INSERT, Screw thread	1	D,E,F,G, YY
-63	71555	BODY, Strainer	1	D,E,F,G, YY
-64	MS29513-134	PACKING, Preformed	1	A,ZZ
-64	MS9021-134	PACKING, Preformed	1	YY
-65	26284	COVER, Filter	1	XX,WW

*Not procurable separately; order NHA.

NO	G. & DEX PART NUMBER	1	2	3	4	5	6	7	DESCRIPTION	UNITS PER ASSY	USABLE ON COL E
MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)											
(ATTACHING PARTS)											
2-1-66	MS20074-03-04	.	BOLT, Machine	4	XX,WW
-67	AN960-10L	.	WASHER, Flat	4	XX,WW
-----*											
-68	MS29513-134	.	PACKING, Preformed	1	M,N
-68	MS9021-134	.	PACKING, Preformed	1	O,WW
-69	23518	.	COVER, "B" Valve	1	
(ATTACHING PARTS)											
-70	14862	.	SCREW, Socket head cap	4	
-71	AN960-10L	.	WASHER, Flat	4	
-----*											
-72	MS29513-130	.	PACKING, Preformed	1	A,ZZ,M,N
-72	MS9021-130	.	PACKING, Preformed	1	YY,O,WW
2-1-	23770	.	"B" VALVE ASSEMBLY	1	A,B
2-1-	†76875	.	"B" VALVE ASSEMBLY	1	C,D,E,F, G,YY,XX, WW
-73	26815	.	CLIP, Spring retainer	1	A,B
-74	23769	.	WASHER, Valve cup	1	A,B
-75	23772	.	SPRING, Check valve	1	A,B
-76	23519	.	SEAT, Valve	1	A,B
-77	23509	.	VALVE, "B"	1	A,B
-77	MS29513-129	.	PACKING, Preformed	1	A,ZZ,M,N
-78	MS9021-129	.	PACKING, Preformed	1	YY,O,WW
-79	24276	.	COVER, "C" Valve	1	
(ATTACHING PARTS)											
-80	14862	.	SCREW, Socket head cap	4	
-81	AN960-10L	.	WASHER, Flat	4	
-----*											
-82	MS29513-024	.	PACKING, Preformed	1	A,ZZ,M,N
-82	MS9021-024	.	PACKING, Preformed	1	YY,O,WW
-83	24275	.	SPRING, Helical compression	1	
-84	24776	.	VALVE, "C"	1	
-85	24774	.	SEAT, "C" Valve	1	
-86	MS29513-023	.	PACKING, Preformed	1	A,ZZ,M,N
-86	MS9021-023	.	PACKING, Preformed	1	YY,O,WW
-87	23665	.	COVER, "D" Valve	1	
(ATTACHING PARTS)											
-88	14862	.	SCREW, Socket head cap	3	
-89	AN960-10L	.	WASHER, Flat	3	
-----*											

† Part No. 76875 differs from Part No. 23770 only in that Part No. 26815 (Index No. 73) is silver-brazed in position, and the "B" valve assembly must be procured as a unit.

FIG. & INDEX NO.	PART NUMBER	1	2	3	4	5	6	7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)											
2-1-90	MS29513-125	.							PACKING, Preformed	1	A,ZZ,M,N
-90	MS9021-125	.							PACKING, Preformed	1	YY,O,WW
-91	23524	.							SPRING, "D" Valve	1	
-92	23695	.							VALVE, "D"	1	
-93	23694	.							SEAT, "D" Valve	1	
-94	MS29513-124	.							PACKING, Preformed	1	A,ZZ,M,N
-94	MS9021-124	.							PACKING, Preformed	1	YY,O,WW
-95	24482	.							COVER, "A" Valve	1	
(ATTACHING PARTS)											
-96	15050	.							SCREW, Socket head cap	4	
-97	AN960-10L	.							WASHER, Flat	4	
-----*											
-98	81153	.							GASKET, Metal retainer	1	K,L,R,S
-99	MS29513-123	.							PACKING, Preformed	1	A,ZZ, M,N
-99	MS9021-123	.							PACKING, Preformed	1	YY,O, WW
-100	41081-5	.							SHIM, "A" Valve spacer, 0.003 - 0.007 in. thk	AR	
-100	41081-10	.							SHIM, "A" Valve spacer, 0.008 - 0.012 in. thk	AR	
-100	41081-20	.							SHIM, "A" Valve spacer, 0.018 - 0.022 in. thk	AR	
-100	41081-30	.							SHIM, "A" Valve spacer, 0.028 - 0.032 in. thk	AR	
-100	41081-50	.							SHIM, "A" Valve spacer, 0.048 - 0.052 in. thk	AR	
-101	24487	.							SPRING, "A" Valve inner	1	
-102	24486	.							SPRING, "A" Valve outer	1	
-103	24483	.							RETAINER, Spring	1	
-104	24484	.							BALL, "A" Valve	1	
-105	24485	.							SEAT, "A" Valve ball	1	
(ATTACHING PARTS)											
-106	14849	.							SCREW, Socket head cap	4	
-----*											
-107	MS29513-014	.							PACKING, Preformed	1	A,ZZ,M,N
-107	MS9021-014	.							PACKING, Preformed	1	YY,O,WW
-108	MS9244-01	.							DECALCOMANIA	1	
-109	47441	.							PLATE, Identification	1	
(ATTACHING PARTS)											
-110	MS24621-2	.							SCREW, Thread forming	2	
-----*											
2-1-	45305	.							HOUSING AND STUD ASSEMBLY	1	A,ZZ, H,XX
2-1-	81603	.							HOUSING AND STUD ASSEMBLY	1	I,J,K, L,WW
-111	41335-L	.							STUD, Min std size, 0.2779 - 0.2789 in. PD	8	
-111	41335-M	.							STUD, Mean std size, 0.2789 - 0.2799 in. PD	8	
-111	41335-H	.							STUD, Max std size, 0.2799 - 0.2809 in. PD	8	
-111	41335-P003	.							STUD, 0.003 in. oversize, 0.2840 - 0.2855 in. PD	8	
-111	41335-P006	.							STUD, 0.006 in. oversize, 0.2870 - 0.2885 in. PD	8	

FIG. & INDEX NO.	PART NUMBER	1	2	3	4	5	6	7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE
MODELS 9450 AND 9484 TWO-STAGE FUEL PUMPS (Cont)											
2-1-112	23654-L	STUD, Min std size, 0.2779 - 0.2789 in. PD	8	
-112	23654-M	STUD, Mean std size, 0.2789 - 0.2799 in. PD . . .	8	
-112	23654-H	STUD, Max std size, 0.2799 - 0.2809 in. PD	8	
-112	23654-P003	STUD, 0.003 in. oversize, 0.2840 - 0.2855 in. PD .	8	
-112	23654-P006	STUD, 0.006 in. oversize, 0.2870 - 0.2885 in. PD .	8	
-113	23655-L	STUD, Min std size, 0.3365 - 0.3376 in. PD	8	
-113	23655-M	STUD, Mean std size, 0.3376 - 0.3387 in. PD . . .	8	
-113	23655-H	STUD, Max std size, 0.3387 - 0.3398 in. PD	8	
-113	23655-P003	STUD, 0.003 in. oversize, 0.3422 - 0.3437 in. PD .	8	
-113	23655-P006	STUD, 0.006 in. oversize, 0.3452 - 0.3467 in. PD .	8	
-114	45306	HOUSING AND PLUG ASSEMBLY	1	A,ZZ, H,XX
-114	81604	HOUSING AND PLUG ASSEMBLY	1	I,J,K,L, WW
2-1-	74499	PARTS KIT, Overhaul ("D" Kit)	1	A
2-1-	75861	PARTS KIT, Cure date items ("C" Kit)	1	A
2-1-	86292	PARTS KIT, Cure date items ("C" Kit) (Replaced 82250)	1	K,L
2-1-	91132	PARTS KIT, Cure date items ("C" Kit) (Replaced 86290 and 86292)	1	S, L
2-1-	91135	PARTS KIT, Overhaul ("D" Kit)	1	S

SHIPPING PACKAGE

2-2-	NO NUMBER	PACKAGE, Shipping	1	
2-2-	27355	CONTAINER ASSEMBLY, Metal shipping	1	
-1	AN8026-2	CONTAINER, Shipping	1	
-2	NO NUMBER	PAD, Tulatex dunnage, 13-1/2 in. dia by 5 in. . . . thk, Type III (density conforming to Military Specification MIL-C-6064)	2	
-3	NO NUMBER	PAD, Tulatex dunnage, 7-1/2 by 12-1/4 by 37 in. lg, Type III (density conforming to Military Specification MIL-C-6064)	1	
-4	NO NUMBER	SHIPPING ASSEMBLY, Pump	1	
-5	77222	COVER, Shipping (KF)	1	

"IN" DATES PROFILE

NAME _____		ALC <u>OC-ALC</u>		DATE <u>31 MAY 89</u>	RCC <u>MTFCB</u>	SHEET <u>1</u> OF <u>1</u>
PCI ISH PRI	<u>97178A</u>	PARENT WCD	<u>82291</u>	PARENT WCD DATE	<u>4/1/89</u>	<u>R</u>
OBSERVATION NUMBER	"II" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	HRS Δ TIME (HOUR)			
1	82291	82291	24			
2	82291	82291	21			
3	83226	83226	21			
4	82242	82242	21			
5	90009	9010	24			
6	90335	9033	21			
7	90440	9041	21			
8	90445	90446	24			
9	90448	9055	26			
10	9055	9060	21			
			<u>23</u>			

NOTE: "II" DATE IS THE DATE THAT SCHEDULING ENTERS IN BLOCK 5 OF WCD ON DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

LSC-2C107A

"OUT" DATES PROC. LE

NAME _____ ALC <u>SC-ALC</u> DATE <u>31 MAY 89</u> RCC <u>MTRO B</u> SHEET <u>1</u> OF <u>1</u>					
PCI JSH PH	97178A	PARENT WCD	PARENT WCD DATE	"OUT" DATE (SCHEDULING SELL DATE)	Δ TIME (HRS)
1	8295			8295	0
2	83678			83678	0
3	83334			83334	0
4	83342			83342	0
5	9013			9013	0
6	9032			9032	0
7	9046			9046	0
8	9055			9055	0
9	9055			9055	0
10	9065			9065	0
11					0

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 1 OF 5

PCN 98021 A WCD CBE COS WCD DATE 88232

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		TIME REQUIRED		EQUIPMENT		DATA SOURCE COMMENTS	
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.
00	MAT PCB	IN	1.0	TRANSIT											
				SETUP											
				PROCESS											
5	MAT PCB	REC	1.0	TRANSIT											
				SETUP											
				PROCESS				BP 09	1		.03				STOCK IN BIN
10	MAT PCB	REC	1.0	TRANSIT											
				SETUP											
				PROCESS				BP 09	1		.17	OK B0410	1		.17
15	MAT PCB	CLN	.02	TRANSIT											
				SETUP											
				PROCESS				BP 09	1		1.5	OK B0410	1		1.5
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME <u>R.S. OLDS</u>		ALC <u>OC</u>		DATE <u>31 MAY 89</u>		RCC <u>MAT PCB</u>		SHEET <u>2</u> OF <u>5</u>					
PCN <u>98021 A</u>		WCD <u>CRC COS</u>		WCD DATE <u>88232</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED	DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.			EQUIPMENT CODE
20	MAT PCB	DIS	.98	TRANSIT									
				SETUP									
				PROCESS									
30	MAT PCB	CLN	.98	TRANSIT									
				SETUP									
				PROCESS									
40	MAT PCB	INSR	.98	TRANSIT									
				SETUP									
				PROCESS									
50	MAT PCB	NDI	.98	TRANSIT									
				SETUP									
				PROCESS									

3 MACHINES
ALL ID #OC 1178

MECHANIC INDICATED THAT
HE DOES NOT
SEND PARTS
OUT FOR REWORK
OR MAG ARTICLE
RETURN

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 3 OF 5

PCN 98021 A WCD CBE COS WCD DATE 88232

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	EQUIPMENT CODE	QTY.	%	HRS.	
60	MAT PCB	INSP	.98	TRANSIT										
				SETUP										
				PROCESS			BP 09	1		B0410	1		.17	
70	MAT PCB	INSP	.98	TRANSIT										TIME INCLUDED IN OP 060
				SETUP										
				PROCESS										
80	MAT PCB	INSP	.98	TRANSIT										OLD OR0 A, OR0 D, OR0 E, OR0 F. THEY NO LONGER REPLACE ANY VALVE PARTS.
				SETUP										
				PROCESS			BP 09	1		B0410	1		.17	
81	MAT PCB	PROC	.05	TRANSIT										OLD OR0 B + C (CONDENSING OF PARTS)
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME <u>R.S. OLDS</u>		ALC <u>OC</u>		DATE <u>31 MAY 89</u>		RCC <u>MATPCB</u>		SHEET <u>4</u> OF <u>5</u>				
PCN <u>98021 A</u>		WCD <u>CBE COS</u>		WCD DATE <u>88 232</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE		
90	MAT PCB	P.W.	.98	TRANSIT								MECHANIC MAKES NEW DATA PLATE FOR ALL UNITS EXCEPT MATROAC
				SETUP								
				PROCESS								
100	MAT PCB	ASSY	.98	TRANSIT								INCLUDES OLD 100, 110, & 120
				SETUP								
				PROCESS								
130	MAT PCB	P.W.	.98	TRANSIT								
				SETUP								
				PROCESS								
140	MAT PCB	TEST	.98	TRANSIT								DO ALL OPS FROM CTE COS HERE
				PROCESS	60	48						
				PROCESS	40	24						
				TRANSIT								
				SETUP								
				PROCESS								

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MAT PCB SHEET 5 OF 5

PCN 98021 A WCD CBE COS WCD DATE 88232

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.	
150	MAT PCB	ASSY	98	TRANSIT											SAFETY WIRES + PWR CABLE INSTALLED
				SETUP											
				PROCESS			BP 09	1		1.0	B0410	1		1.0	
160	MAT PCB	P.W.	98	TRANSIT											
				SETUP											
				PROCESS			BP 09	1		.17					
170	MAT PCB	MOVE	98	TRANSIT											
				SETUP											
				PROCESS			BP 09	1		.03					
180	MAT PCB	P.W.	98	TRANSIT											TIME INCLUDED IN 160
				SETUP											
				PROCESS											
9999	MAT PCB	OUT		TRANSIT											
				SETUP											
				PROCESS											
						24								0	

FLOW PROCESS CHART
SUBJECT PUMP TWO STAGE FUEL

DATE 1 JUN 89

WCD CBE COS WCD DATE 88232

00X

98021A

CHART BEGINS 00 IN

CHART ENDS 9999 OUT

PREPARED BY R. S. JCLDS

[illegible]

INSPECTION

D DELAY

OPERATION PROFILE

NAME <u>R.S. OLDS</u>		ALC <u>OC</u>		DATE <u>31 MAY 89</u>		RCC <u>MATPCB</u>		SHEET <u>1</u> OF <u>3</u>			
PCN <u>98021A</u>		WCD <u>CTE COS</u>		WCD DATE <u>88231</u>							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MANPOWER SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT EQUIPMENT CODE QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
00	MAT PCB	IN	1.0	TRANSIT SETUP PROCESS	40						RECEIVED AT TEST LOCATION
5	MAT PCB	REC	1.0	TRANSIT SETUP PROCESS			DP 09 1	0.5	OC0889 1	0.5	
10	MAT PCB	ASSY	1.0	TRANSIT SETUP PROCESS			DP 09 1	0.5	OC0889 1	0.5	MOUNT P/M20 ON TEST STAND
20	MAT PCB	TEST	1.0	TRANSIT SETUP PROCESS			DP 09 1	1.0	OC0889 1	1.0	5-10% NEED Rework (minors) ON FLOW TEST STAND (15-30 min) ~ 2% OF TOTAL IS MATERIAL
30	MAT PCB	INSP	1.0	TRANSIT SETUP PROCESS			DP 09 1	0.10	OC0889 1	0.10	

OPERATION PROFILE

NAME <u>R.S. OLDS</u>		ALC <u>OC</u>		DATE <u>31 MAY 89</u>		RCC <u>MATPCB</u>		SHEET <u>2</u> OF <u>3</u>							
PCN <u>98021 A</u>		WCD <u>CTE COS</u>		WCD DATE <u>88231</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		
40	MAT PCB	TEST	1.0	TRANSIT											INCLUDED ONS 40, 50, 60 + 70 FROM WCD.
				SETUP											
				PROCESS											
80	MAT PCB	INSP	1.0	TRANSIT											
				SETUP											
				PROCESS											
90	MAT PCB	TEST	1.0	TRANSIT											
				SETUP											
				PROCESS											
100	MAT PCB	P.W.	1.0	TRANSIT											
				SETUP											
				PROCESS											
110	MAT PCB	PROC.	1.0	TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME R.S. OLDS ALC OC DATE 31 MAY 89 RCC MATPCB SHEET 3 OF 3

PCN 98021 A WCD CTE COS WCD DATE 88 231

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	EQUIPMENT CODE	QTY.	%	HRS.	
120	MAT PCB	ASSY	1.0	TRANSIT										TIME INCLUDED IN OP 140
				SETUP										
				PROCESS										
9999	MAT PCB	OUT	1.0	TRANSIT										OP 130 INCLUDED
				SETUP										
				PROCESS										
				TRANSIT		24							0	
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

SUBJECT TEST - PUMP TWO STAGE FUEL

DATE 1 JUN 89

ITEM CODE
PCN
NSN
P/N

WCD CTG COS

WCD DATE 88231

98021 A

CHART BEGINS 00 IN

CHART ENDS 9999 OUT

PREPARED BY R. S. Ocas

[illegible]

○ OPERATION

TRANSPORTATION

▽ STORAGE

D DELAY

☐ INSPECTION

LSC-20147

FLOW PROCESS CHART

SUBJECT TF33 MANIFOLDS LEFTSIDEDATE 26 MAY 89

ITEM CODE

WCD CRECO4WCD DATE 89087PCN
NSN
PM98034A (P1) ~~98043A~~
~~98042A (P1)~~ 98057A

CHART BEGINS

IN

CHART ENDS

9999PREPARED BY S. KOBYLAK

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○●□□▽	RECT. SECTION TO TEST NO. 1	290	290	●□□□▽	ASSEMBLE
040	040	●□□□▽	REPAIR PUMP SEALING EXHAUST	330	330	●□□□▽	INSTALL CAPS
041	030	○□□□▽	DISTORTION CHECK	340	340	●□□□▽	PAPER WORK
—	035	○□□□▽	CHECK THICKNESS	—	320	●□□□▽	IDENTIFY PART
042	—	○□□□▽	NON-DESTRUCTIVE SONIC TEST	350	350	●□□□▽	TEST PART
043	—	●□□□▽	OL NOZZLES	370	370	●□□□▽	TIGHTEN SLEEVES
044	020	●□□□▽	REMOVE NOZZLES	—	390	○□□□▽	CHECK PART
045	020	○□□□▽	INSPECT PARTS	380	380	●□□□▽	REMOVE CAPS LAP PART
046	010	●□□□▽	IDENTIFY & ATTACH PW	400	400	●□□□▽	CAP PART & BOLT TO FRAME
047	—	○□□□▽	RE-TOG BAD PARTS	410	410	●□□□▽	CHECK ID
050	050	●□□□▽	CLEAN PARTS	—	420	●□□□▽	PAPER WORK
055	055	●□□□▽	REMOVE HEATSHIELDS	—	435	●□□□▽	CHECK COMPLIANCE
060	060	○□□□▽	INSPECT PARTS	440	440	○□□□▽	PICK UP STATION
090	090	●□□□▽	REPAIR NOZZLES			○□□□▽	
100	100	●□□□▽	REMOVE/REPLACE SLEEVES			○□□□▽	
110	110	○□□□▽	INSPECT LUGS			○□□□▽	
140	140	●□□□▽	REPAIR LUGS			○□□□▽	
142	142	●□□□▽	MACHINE LUGS			○□□□▽	
145	145	●□□□▽	REPAIR INLET			○□□□▽	
150	150	○□□□▽	INSPECT PARTS			○□□□▽	
155	155	●□□□▽	PERFORM MOD.			○□□□▽	
160	160	●□□□▽	DISTORTION CHECK BEND STRAIGHT			○□□□▽	
165	160	○□□□▽	INSPECT PARTS			○□□□▽	
—	165	●□□□▽	INSPECT HEAT- SHIELD & LOCKWIRE			○□□□▽	
170	170	●□□□▽	TEST			○□□□▽	
210	210	●□□□▽	DRILL HOLES			○□□□▽	
215	215	●□□□▽	FLUSH PART			○□□□▽	
220	220	●□□□▽	INJECT SILICON			○□□□▽	
230	230	●□□□▽	BAKE PART			○□□□▽	
260	260	●□□□▽	LAP SEATS			○□□□▽	
270	270	●□□□▽	CLEAN PART			○□□□▽	
280	280	●□□□▽	MEASURE NOZZLE			○□□□▽	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

D DELAY

LSC-20147

"IN" DATES PROBLE

NAME _____		ALC <u>GC-NIC</u>	DATE <u>31 MAY 89</u>	RCC <u>MTPCB</u>	SHEET <u>1</u> OF <u>1</u>
PCI HSH PIN	<u>98051A</u>	PARENT WCD	PARENT WCD DATE		
OBSERVATION NUMBER	"II" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (DATE)		
1	8292	8292	24	HRS	
2	8302	8302	24		
3	8302	8333	021		
4	8240	8324	24		
5	8247	8324	24		
6	9021	9030	24		
			40		

NOTE: "II" DATE IS THE DATE THAT SCHEDULING EITERS III BLOCK 5 OF WCD ON DATE
THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

OPERATION PROFILE

PER H. JOHNSON

WORKED FROM E. POTTERS

Cell 11

NAME PIRANT ALC OC DATE 060686 RCC MATPCB 50135A, 50132B
 PCH 98031A WCD CBEC06 WCD DATE 89023 SHEET 1 OF 4

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANIPULATOR			EQUIPMENT			DATA SOURCE COMMENTS
					%	INS.	QTY.	%	INS.	QTY.	EQUIPMENT CODE	%	INS.	
00	MATP CB	IN TIME	1.0	TRANSIT										
				SETUP										
				PROCESS		30								
10	MATP CB	REC	1.0	TRANSIT										REC, ID T
				SETUP										ATTACH
				PROCESS			AP09	100	.5	BEN53	1	100	.5	PW
20	MATP CB	DIS	1.0	TRANSIT										AVOID SCRAP OR REWORK DAMAGE
				SETUP										
				PROCESS			AP09	100		BEN53	1	100		
30	MATP CB	CLN	1.0	TRANSIT										
				SETUP						OC447	1	100	.2	
				PROCESS			AP09	100	.4	OC4132	1	100	.2	
60	MATP CB	PROC	1.0	TRANSIT										
				SETUP										1.0
				PROCESS			AP09	100	.7	BEN53	1	100	.7	Inspection

OPERATION PROFILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>060689</u>		RCC <u>CBECOG</u>		SHEET <u>2</u> OF <u>4</u>			
PCN <u>98031A</u>		WCD <u>CBECOG</u>		WCD DATE <u>89023</u>							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MAIN POWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	INS.	QTY.	%	INS.	EQUIPMENT CODE	
70	MATP CB	INSP	1.0	TRANSIT SETUP PROCESS			AP09 1	100 7	30153 1	100 7	Inspect PRIMARY SIRANEN.
90	MATP CB	ASSY	1.0	TRANSIT SETUP PROCESS			AP09 1	100 4.5	BENSE 1	100 4.5	ASSY. O.D.M.C. SERVANT BODY
100	MATP CB	MOVE	1.0	TRANSIT SETUP PROCESS			AP09 1	100 3	FENSE 1	100 3	MOVE TO CAPTAIN'S
110	MATP CB	PREC	1.0	TRANSIT SETUP PROCESS							L.A.P. SEAL SURFACES
120	MATP CB	CLN	1.0	TRANSIT SETUP PROCESS			AP09 1	100 1.8	PROCESS 10	100 1.8	CLN (644110) P.D. 686

OPERATION FILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>060689</u>		NCC <u>CBECOG</u>		SHEET <u>3</u> OF <u>4</u>				
PCN <u>98031A</u>		WCD <u>CBECOG</u>		WCD DATE <u>89023</u>								
OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % INH.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % INH.	EQUIPMENT CODE	QTY.	TIME REQUIRED % INH.	DATA SOURCE COMMENTS
150	MATP CB	MOV	1.0	TRANSIT SETUP PROCESS		AP09	1	100 .3				MOBILE TO 4 REC. ROOM TEST. AT. N4 WCD
152	MATP CB	PROD.	1.0	TRANSIT SETUP PROCESS		AP09	1	100 .2	BEN53	1	100 .2	VACU-BLAST
155	MATP CB	INSP	1.0	TRANSIT SETUP PROCESS		AP09	1	100 1.6	BEN53	1	100 1.6	VISUAL INSP. NETS MICR. ALSO.
160	MATP CB	ASSY	1.0	TRANSIT SETUP PROCESS								ASSY FERRULE, SCREEN, SPRING.
170	MATP CB	INSP	1.0	TRANSIT SETUP PROCESS		AP09	1	100 .3	BEN53	1	100 .3	

[illegible]

NAME <u>P HUNT</u>		ALC <u>DC</u>		DATE <u>060689</u>		RCC <u>CBECOG</u>		SHEET <u>4</u> OF <u>4</u>					
PCH <u>98031A</u>		WCD <u>CBECOG</u>		WCD DATE <u>89023</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.	QTY.	SKILL CODE/LEVEL	QTY.	EQUIPMENT CODE			
175	MATP CB	C/W PW	1.0	TRANSIT									C/W MAOS 66-36 P. 13.
				SETUP									
				PROCESS									
180	MATP CB	MOVE	1.0	TRANSIT									MOVE TO ACK UP STATION
				SETUP									
				PROCESS									
9994	MATP CB	OUT DATE	1.0	TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

OPERATIC PROFILE TEST

NAME PHUNT ALC OC DATE 6-2-89 RCC MATPCB SHEET 1 OF 3

PCN
NSN
PIN

98031A

WCD CTEC06

WCD DATE 8712

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
00	MATP CB	IN DATE	1.0	TRANSIT							
				SETUP							
				PROCESS	30						
010	MATP CB	TST	1.0	TRANSIT							
				SETUP							
				PROCESS		DP09 1	100 .08	06 0705 06 0701 06 0702 06 0703	1	100 .03 100 .03 100 .03	VISUAL CHECK SPRAY PATTERN
020	MATP CB	TST	1.0	TRANSIT							
				SETUP							
				PROCESS		DP09 1	100 .08	06 0705 06 0701 06 0702 06 0703	1	100 .03 100 .03 100 .03	FLOW RATE
030	MATP CB	TST	1.0	TRANSIT							
				SETUP							
				PROCESS							
040	MATP CB	TST		TRANSIT							
				SETUP							
				PROCESS		DP09 1	100 .08	06 0705 06 0701 06 0702 06 0703	1	100 .03 100 .03 100 .03	300 PSIG - CHK FOR SPRAY STREAKINESS.
				TRANSIT							
				SETUP							
				PROCESS		DP09 1	100 .08	06 0705 06 0701 06 0702 06 0703	1	100 .03 100 .03 100 .03	SPRAY CONE ANGLE.

OPERATION PROFILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>6-2-89</u>		RCC <u>MATPCB</u>		SHEET <u>2</u> OF <u>3</u>					
PCN <u>98031A</u>		WCD <u>CIEC06</u>		WCD DATE <u>8712</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS	
050	MATP CB	TEST	1.0	TRANSIT								SPRAY CONE ALIGNMENT	
				SETUP									
				PROCESS									
060	MATP CB	TEST	1.0	TRANSIT								REWORK & CALIB ALLOWANCE	
				SETUP									
				PROCESS									
070	MATP CB	PW	1.0	TRANSIT								C/W IAW T.O. TETO ETC.	
				SETUP									
				PROCESS									
075	MATP CB	PW	1.0	TRANSIT								C/W, MAOI 66-36 PARA. 13	
				SETUP									
				PROCESS									
080	MATP CB	MOVE	1.0	TRANSIT								MOVE TO FINAL ASSY	
				SETUP									
				PROCESS									

OPERATION PROFILE

NAME <u>P Hunt</u>		ALC <u>OC</u>		DATE <u>6-2-89</u>		RCC <u>MATP CB</u>		SHEET <u>3</u> OF <u>3</u>					
PCN <u>98031A</u>		WCD <u>CTEC06</u>		WCD DATE <u>87112</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.		
9999	MATP CB	OUT DATE	1.0	TRANSIT	24								
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

DATE 6-2-89

WCD CTEC 06 WCD DATE 87112

VIS check

OP 80 MOVE TO ASSY PREPARED BY J Hunt

D DELAY

"IN" DATES PROFILE

NAME _____ ALC <u>ALC</u> DATE <u>5/11/14</u> RCC <u>MTPCB</u> SHEET <u>1</u> OF <u>1</u>			
PCH ISH PHI	08031A		
PARENT WCD	PARENT WCD DATE		
OBSERVATION NUMBER	"IN" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (HRS)
1	8307 8307	8308	24
2	8326	8326	0.
3	8340	8340	0
4	8358	8362	46
			(24)

NOTE: "IN" DATE IS THE DATE THAT SCHEDULING EITERS IN BLOCK 5 OF WCD OR DATE THAT SCHEDULING ATTACHES A WCD TO AN ASSET TO BE WORKED.

[illegible]

UNIFORM "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE JCC.

LSC-20103A

NAME KOBYL K ALC OC-ALC DATE 25 MAY 89 RCC MAT-BE SHEET 1 OF 9

PCN	98034A	98043A
NBN	98042A	98057A

WCD CRCOY WCD DATE 89087

OPERATION NUMBER	ROC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.		TIME REQUIRED	
								%	HRS.				%	HRS.
000	MAT CB	IN	1.0	TRANSIT										
				SETUP										
				PROCESS	0									
010	MAT PCB	REC	1.0	TRANSIT								80% OF MAN. REC FROM THE "BARN"		
				SETUP								20% OF MAN. REC FROM THE "BARN"		
				PROCESS		BPO9	1	100	1	BENSS	1	100	RECEIVE 25 AT FROM "BARN"	
													A MIX OF LEFT MANUFACTURE	
				TRANSIT									REMOVE PART FROM SHIPING FIXTURE	
				SETUP									CHECK FIXTURE DISTORTION	
				PROCESS										
040	CB	REM	1.0	TRANSIT									WCD 040	
				SETUP									INSPECT MANIFOLD FOR DISTORTION	
				PROCESS									IF MAN. SEND HAVE BEEN F SEND TO (NEW) B	
041	CB	INSP	1.0	TRANSIT									WCD 040	
				SETUP									WCD 040	
				PROCESS		BPO9	1	100	0.05	BENSS	1	100	WCD 040	
													INSPECT MANIFOLD FOR DISTORTION	
				TRANSIT									IF MAN. SEND HAVE BEEN F SEND TO (NEW) B	
				SETUP									WCD 040	
				PROCESS		BPO9	1	100	0.05	BENSS	1	100	WCD 040	
													INSPECT MANIFOLD FOR DISTORTION	
				TRANSIT									IF MAN. SEND HAVE BEEN F SEND TO (NEW) B	
				SETUP									WCD 040	
				PROCESS		BPO9	1	100	0.05	BENSS	1	100	WCD 040	
													INSPECT MANIFOLD FOR DISTORTION	
				TRANSIT									IF MAN. SEND HAVE BEEN F SEND TO (NEW) B	
				SETUP									WCD 040	
				PROCESS		BPO9	1	100	0.05	BENSS	1	100	WCD 040	
													INSPECT MANIFOLD FOR DISTORTION	
				TRANSIT									IF MAN. SEND HAVE BEEN F SEND TO (NEW) B	
				SETUP									WCD 040	
				PROCESS		BPO9	1	100	0.05	BENSS	1	100	WCD 040	
													INSPECT MANIFOLD FOR DISTORTION	
				TRANSIT									IF MAN. SEND HAVE BEEN F SEND TO (NEW) B	
				SETUP									WCD 040	
				PROCESS		BPO9	1	100	0.05	BENSS	1	100	WCD 040	
													INSPECT MANIFOLD FOR DISTORTION	
				TRANSIT									IF MAN. SEND HAVE BEEN F SEND TO (NEW) B	
				SETUP									WCD 040	
				PROCESS		BPO9	1	100	0.05	BENSS	1	100	WCD 040	
													INSPECT MANIFOLD FOR DISTORTION	
				TRANSIT										

OPERATION PROFILE

NAME <u>KOBYLK</u>		ALC <u>OC-ALC</u>		DATE <u>25 MAY 89</u>		RCC <u>MA TCBE</u>		SHEET <u>2</u> OF <u>9</u>						
ITEM CODE <u>PCN 98034A 98042A 98052A</u>		WCD <u>CBE C04</u>		WCD DATE <u>8 9087</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.			TIME REQUIRED %
043	CB	PROC	.98	TRANSIT	1.0	BPO9	1	100	.05	BENSS	1	100	.05	OIL PUT ON NOZZLES AND LEFT ON FOR ONE HOUR TO SATURATE THREADS FOR EASY REMOVAL.
				SETUP										
				PROCESS										
044	CB	REM	1.0	TRANSIT									IF POSSIBLE, DISCARD OLD SEALS & LOCK TAPS	
				SETUP										
				PROCESS										
045	CB	INSP	1.0	TRANSIT		BPO9	1	100	.17	BENSS	1	100	.17	WCD 020 INSPECT PART FOR CRACKS, STUCK TAPS AND FROZEN NOZZLES
				SETUP										
				PROCESS										
046	CB	ID	1.0	TRANSIT		BPO9	1	100	.03	BENSS	1	100	.03	WCD 020 IDENTIFY PARTS AND ATTACH PAR RING
				SETUP										
				PROCESS										
047	CB	INSP	.2	TRANSIT		BPO9	1	100	.05	BENSS	1	100	.05	SECOND PART OF WCD 010 20% OF PARTS ARE TO BE REMOVED FOR TAP / AIR IN TAPED AND SCRAPED.
				SETUP										
				PROCESS										
				TRANSIT		BPO9	1	100	.08	BENSS	1	100	.08	
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME <u>KOBYLK</u>		ALC <u>OS-ALC</u>		DATE <u>25 MAY 1979</u>		ROC <u>MATCBE</u>		SHEET <u>3</u> OF <u>9</u>					
ITEM CODE		PCN <u>98034A</u>		WCD <u>CBEC04</u>		WCD DATE <u>89087</u>							
OPERATION NUMBER		ROC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER	EQUIPMENT	DATA SOURCE COMMENTS				
							SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %	HRS.	
050	CB	CLN	1.0	TRANSIT									
				SETUP									
				PROCESS									
055	MT PIW	REM	1.0	TRANSIT									
				SETUP									
				PROCESS									
060	IW	INSP	1.0	TRANSIT									
				SETUP									
				PROCESS									
090	MT PCM	REP	1.0	TRANSIT									
				SETUP									
				PROCESS									
100	CM	REPL	1.0	TRANSIT									
				SETUP									
				PROCESS									

PARTS ARE BATCHED
PROCESSED. THEY ARE
PLACED ON RACKS +
CLEANED.
2 PARTS PER TANK
2 TANKS AVAILABLE PER PROCESS

WCD 050
REMOVE
HEATSHIELD

WCD 055
INSPECT FOR
METAL CORROSION
(GOLD-NICKEL)
(COPPER-NICKEL)

WCD 060
REPAIR
NOZZLE BODY
AS REQUIRED

WCD 090
REMOVE +
REPLACE
SEALING AS
REQUIRED

WCD 100

NAME <u>KOBYLK</u>		ALC <u>OC-ALC</u>		DATE <u>25 MAY 89</u>		ROC <u>MATCBE</u>		SHEET <u>4</u> OF <u>9</u>	
ITEM CODE <u>PCN 98034A 98043A</u>		WCD <u>CBE04</u>		WCD DATE <u>89087</u>					
PIN <u>98042A 98057A</u>		MANDATORY OCCURRENCE FACTOR		OPERATION DESCRIPTION		MANDATORY OCCURRENCE FACTOR		OPERATION TYPE	
OPERATION NUMBER		ROC		OPERATION DESCRIPTION		MANDATORY OCCURRENCE FACTOR		OPERATION TYPE	
MANPOWER		EQUIPMENT		TIME REQUIRED		TIME REQUIRED		TIME REQUIRED	
SKILL CODE/LEVEL		QTY.		%		HRS.		HRS.	
MANDATORY FLOW HOURS		EQUIPMENT CODE		QTY.		%		HRS.	
110	CM	INS	1.0	TRANSIT					
		SETUP							
		PROCESS							
120	MT PIW	PROC	1.0	TRANSIT					
		SETUP							
		PROCESS							
140	MT PCM	REPL	1.0	TRANSIT					
		SETUP							
		PROCESS							
142	CM	MACH	1.0	TRANSIT					
		SETUP							
		PROCESS							
145	CM	REP	1.0	TRANSIT					
		SETUP							
		PROCESS							

OPERATION NUMBER	ROC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.		TIME REQUIRED	
								%	HRS.				%	HRS.
110	CM	INSP	1.0	TRANSIT								INSPECT + RECORD LUG THICKNESS		
				SETUP										
				PROCESS										
120	MT PIW	PROC	1.0	TRANSIT								WCD 110 WELD HEATSHIELD AND LUGS AS REQUIRED + INSPECTION WORK		
				SETUP										
				PROCESS										
140	MT PCM	REPL	1.0	TRANSIT								WCD 120 REPAIR OR REPLACE LUGS AS REQUIRED		
				SETUP										
				PROCESS										
142	CM	MACH	1.0	TRANSIT								WCD 140 MACHINE LUGS + RECORD THICKNESS		
				SETUP										
				PROCESS										
145	CM	REP	1.0	TRANSIT								WCD 142 REPAIR INLET ADAPTERS AND BUSHINGS IF REQUIRED		
				SETUP										
				PROCESS										
													WCD 145	

[illegible]

NAME KOBYLKA ALC QC-ALC DATE 25 MAY 89 RCC MATCBF SHEET 6 OF 9

ITEM CODE	PCN	NBN	PIN	OPERATION NUMBER	ROC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS						
										SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED %	HRS.				
210	98034A	98042A	98057A	MT PCM	PROC	1.0		TRANSIT								DRILL HOLES FOR SILICON						
								SETUP														
								PROCESS														
215	98034A	98042A	98057A	MT PIW	CLN	1.0		TRANSIT								WCD 210 REFLUSH MANIFOLD						
								SETUP														
								PROCESS														
220	98034A	98042A	98057A	IW	PROC	1.0		TRANSIT								WCD 2.5 INJECT SILICON						
								SETUP														
								PROCESS														
230	98034A	98042A	98057A	IW	PROC	1.0		TRANSIT								WCD 220 BAKE MANIFOLD REMOVE RESIDUE 4 HRS IN WORK 12 HR WAIT UNIT NEXT MORNING						
								SETUP														
								PROCESS														
250	98034A	98042A	98057A	MAT CB	INSP	1.0		TRANSIT								WCD 230 - INSPECT TAKES ABOUT 5-10 SECONDS						
								SETUP														
								PROCESS														
									16													
										809	1	100	0.01	4	1	100	0.01	WCD 250				

NAME		KOBLYK		ALC OC-ALC		DATE 25 MAY 89		RCC MATCHBLF		SHEET 7 OF 9				
ITEM CODE		PCN 98034A 98043A NON 98042A 98057A		WCD CRECOY		WCD DATE 89087								
OPERATION NUMBER	ROC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS		
						SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.
260	CB	PROC	1.0	TRANSIT								BODY SEATS ARE LAPPED BY HAND WCD 260		
				SETUP										
				PROCESS										
						BPO9	1	100	2.0	PEN-F	1	100	2.0	- PART IS FLUSHED AND AIR DRIED
270	CB	CLN	1.0	TRANSIT								MEASURE NOZZLE AND BODY HOUSING DEPTH. SUBTRACT ONE FROM THE OTHER TO DETERMINE WHAT SIZE SEAL IS REQUIRED WCD 270		
				SETUP										
				PROCESS										
						BPO9	1	100	.25	VUL JANK	1	100	.25	
280	CB	PROC	1.0	TRANSIT								INSTALL SEALS NOZZLES AND TAB LOCKS WCD 280		
				SETUP										
				PROCESS										
						BPO9	1	100	.4	PEN-F	1	100	.4	
290	CB	ASSY	1.0	TRANSIT								WCD 290		
				SETUP										
				PROCESS										
						BPO9	1	100	.5	PEN-F	1	100	.5	
330	CB	INT	1.0	TRANSIT								- INSTALL CAPS ON NOZZLES WCD 330		
				SETUP										
				PROCESS										
						BPO9	1	100	.01	PEN-F	1	100	.01	

OPERATION PROFILE

NAME <u>K03VLK</u>		ALC <u>OC-ALC</u>		DATE <u>25 MAY 89</u>		RCC <u>MATCISE</u>		SHEET <u>8</u> OF <u>9</u>	
ITEM CODE <u>98031A</u>		PCN <u>98031A</u>		WCD <u>CEC04</u>		WCD DATE <u>89087</u>			
PIN <u>98031A</u>		MANDATORY OCCURRENCE FACTOR		OPERATION TYPE		MANPOWER		EQUIPMENT	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.
340	CB	FW	1.0	TRANSIT					
				SETUP					
				PROCESS					
						BPO9	1	100	.09
									100 .09
350	CB	TEST	1.0	TRANSIT					
				SETUP					
				PROCESS	16				
370	CB	PROC	1.0	TRANSIT					
				SETUP					
				PROCESS					
						BPO9	1	100	.4
									100 .4
380	CM	PROC	1.0	TRANSIT					
				SETUP					
				PROCESS	.25				
400	CB	LOAD	1.0	TRANSIT					
				SETUP					
				PROCESS					
						BPO9	1	100	.15
									100 .15

WCD 320+340
CONVEYER TO
BLOG 3108
FOR TESTING
WCD CTECO
AND RETURNED
BY CONVEYER
WCD 350
TIGHTEN SEALS,
SET TAB LOCKS,
PERFORM DISTURBANCE
CHECK BY VISUAL
AND FEEL
WCD 370+390
REMOVE CAPS
AND HAND
LAP TO A
FINE FINISH,
WCD 380
CAP PART
AND BOOST TO
FINE FINISH
WCD 400

NAME KOBYLK ALC OC-ALC DATE 25 MAY 89 RCC 1 MATC 135- SHEET 9 OF 9

[illegible]

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMK
26 - 63	410935	52661		RING-SPL, RTNG 0.938 HSG DIA X 0.075 WALL X 0.042 IN. THK	1		PAFBZN
- 64	742372	52661		GEARSHAFT-BEVEL, MAIN DRIVE GRBX SHAFT	1		PAFFFFP
- 65	770329	52661		BEARING OPTION-REF NO. ONLY	1		XC—
	741415	52661		ORDER ONE OF THE FOLLOWING BEARING-RLR, CYL 1.4949 X 3.3999 X 0.952, OPTL TO 741416			PAFBZN
	741416	52661		BEARING-RLR, CYL 1.4949 X 3.3999 X 0.952, OPTL TO 741415			PAFBZN
- 66	742366	52661		SPACER-RING 1.500 ID X 1.860 OD X 0.080 IN. THK	1		PAFZZN
- 67	742365	52661		SPACER-BRG ACCESS DRIVE GRSHFT	1		PAFZZN
	801659	52661		BEARING ASSEMBLY-GRBX DRIVE SUPERSEDES 742369	1		XB—
- 68	742368	52661		HOUSING-GRBX DRIVE BRG	1		PAFBZN
- 69	802862	52661		BEARING OPTION-REF NO. ONLY	1		XC—
				ORDER THE FOLLOWING SUPERSEDES 488748 OPTION C/O 488747 OR 770612 PRCMT NO. C/O			
	798868	52661		BEARING-BALL 35 MM X 72 MM X 17 MM, OPTL TO 798869			PAFBZN
	798869	52661		BEARING-BALL 35 MM X 72 MM X 17 MM, OPTL TO 798868			
- 70	749920	52661		SPACER ASSEMBLY-GRBX DRIVE BRG	1		PAFZZN
- 71	MS9390-080	96906		.PIN	1		PADZZN
- 72	742378	52661		HOUSING-ASSY OF, GRBX DRIVE BRG	1		PAFBZN

R
R
R

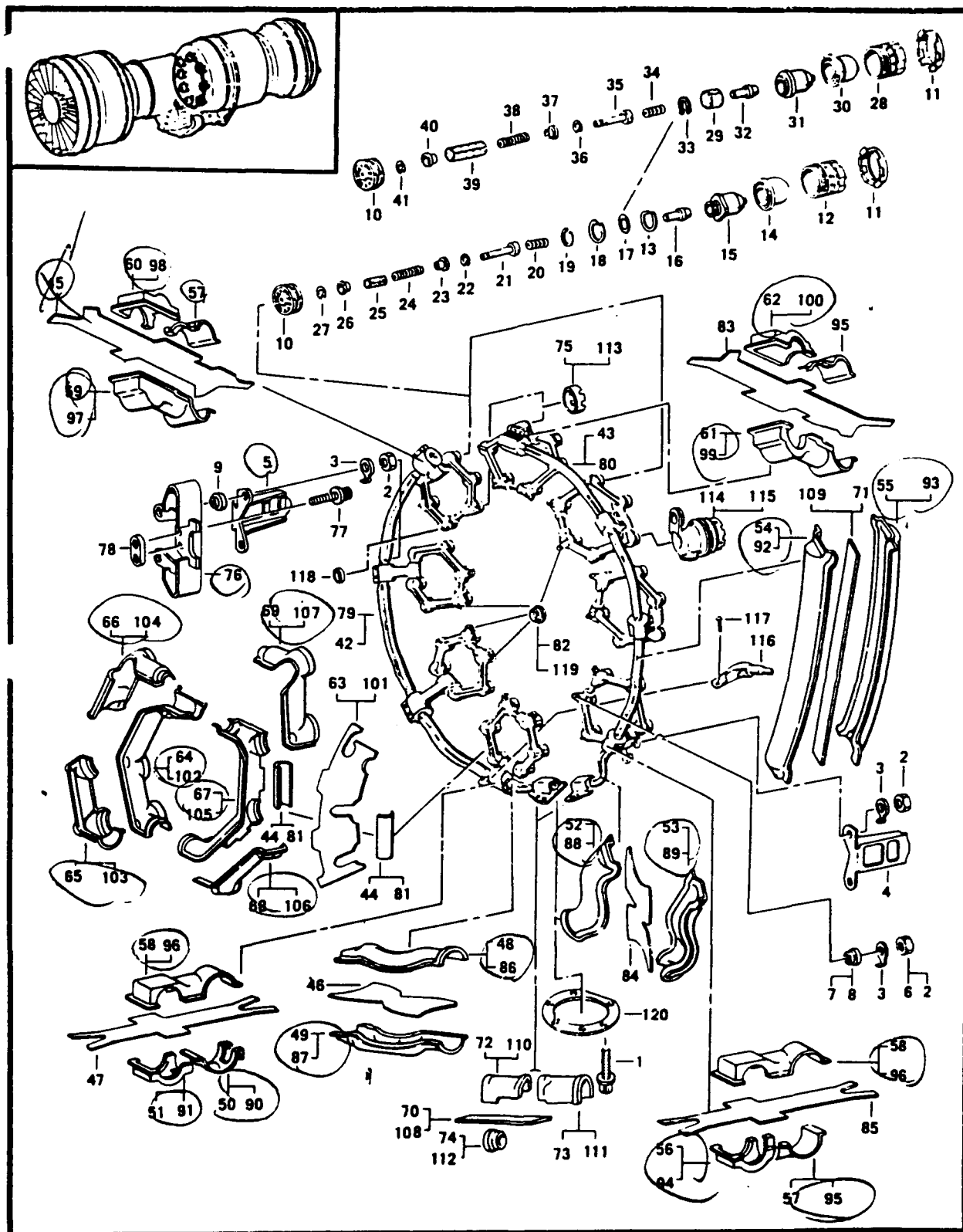


FIGURE 27 - MANIFOLDS-FUEL. NOZZLES-FUEL.

PCN 98034A 98043A
 98042A 98057A

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27	483266	52661		MANIFOLDS-FUEL. NOZZLES-FUEL.			
- 1	524342	52661		MANIFOLD SET-FUEL	1	AS	XB---
	237233	52661		MANIFOLD SET-FUEL	1	B/AT	XB---
- 2	MS9356-10	96906		BOLT-MACH. DRILLED DBL HEX	6		PAFZZN
				0.3125-24 X 0.500 IN. LONG (AP)			
	MS9356-10	96906		NUT (AP)	32	AS	PAFZZN
				SUPERSEDES AN121527			
				FOR A ENG			
- 3	227340	52661		NUT (AP)	16	AT	PAFZZN
- 4	435348	52661		SUPERSEDES AN121527			
- 5	454391	52661		FOR A ENG			
- 6	MS9357-10	96906		WASHER-KEY 0.2575 ID X 0.055 (AP)	32		PAFZZN
				BRACKET-COMB CHMBR (AP)	2		PAFZZN
				BRACKET-COMB CHMBR FR (AP)	6		PAFZZN
				NUT (AP)	16	B/AT	PAFZZN
				SUPERSEDES 328835			
				FOR A ENG			
- 7	524325	52661		LOCK-FUEL MANF (AP)	16	B/AT	PAFZZN
- 8	490029	52661		LOCK-FUEL NOZ HSG (AP)	16	AS	PAFZZN
- 9	483263	52661		BUSHING-SLV 0.260 X 0.440 X 0.459,	12		PAFZZN
				FLG (AP)			
	483268	52661		MANIFOLD AND NOZZLE-ASSY OF, FUEL,	1	AS	PAFDDT
				RIGHT, PREFERRED U/W			
				483266 MANF SET			
	483267	52661		MANIFOLD AND NOZZLE-ASSY OF, FUEL,	1	AS	PAFDDT
				LEFT, PREFERRED U/W			
				483266 MANF SET			
	563217	52661		MANIFOLD AND NOZZLE-ASSY OF, FUEL,	1	B/AT	PAFDDT
				RIGHT, PREFERRED U/W			
				524342 MANF SET			
				SUPERSEDES 524311			
	563215	52661		MANIFOLD AND NOZZLE-ASSY OF, FUEL,	1	B/AT	PAFDDT
				LEFT, PREFERRED U/W			
				524342 MANF SET			
				SUPERSEDES 524340			
- 10	218406	52661		SEAL-FUEL NOZ, ALSO REQD FOR SVCE ...	24		PAFZZN
				REPAIR OF FUEL MANF AND NOZ			
				ASSY			
	749885	52661		SEAL-FUEL NOZ, ALSO REQD FOR SVCE ...	24		PAFZZN
				REPAIR OF FUEL MANF AND NOZ			
				ASSY			
- 11	431839	52661		WASHER-KEY, FUEL NOZ	24		PAFZZN
	157872	52661		TABWASHER-FUEL NOZ, AIR FORCE	48		
				ASSIGNED APPLICATION			
	481694	52661		NOZZLE ASSEMBLY-FUEL, REPAIR KIT	24	AU	PAFDDT
				500072 AVAILABLE			
- 12	484454	52661		NUT-FUEL NOZ	1	AU	PAFZZN
	484455	52661		NOZZLE SET-FUEL	1	AU	ADD---
- 13	267829	52661		RING-RTNG 0.750 OD X 0.040 WIDE	1	AU	KD---
				X 0.0165 IN. THK			
- 14	739595	52661		NOZZLE-FUEL	1	AU	PADBZN
- 15	739596	52661		NOZZLE-FUEL	1	AU	PADBZN
- 16	739597	52661		METERING PLUG-NOZZLE	1	AU	PADBZN
- 17	484452	52661		STRAINER ELEMENT-SCREEN 0.495	1	AU	KD---
				CONTINUED			

FIGURE INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27				ID X 0.756 OD X 0.00375 IN. THK			
- 18	267630	52661	...	RING-RTNG 0.813 OD X 0.040 WIDE X 0.0165 IN. THK	1	AU	KD---
- 19	267631	52661	...	RING-RTNG 0.453 OD X 0.040 WIDE X 0.0165 IN. THK	1	AU	KD---
- 20	267627	52661	...	SPRING-HLCPS 0.213 OD X 0.036 IN. DIA WIRE	1	AU	PADZZN
- 21	267626	52661	...	SUPPORT-FUEL NOZ	1	AU	PADZZN
- 22	267632	52661	...	RING-RTNG 0.312 HSG DIA X 0.015 IN. THK	1	AU	KD---
- 23	267624	52661	...	FLANGE-FUEL NOZ	1	AU	PADZZN
- 24	368448	52661	...	SPRING-HLCPS 0.246 OD X 0.159 IN. DIA WIRE	1	AU	PADZZN
- 25	484453	52661	...	STRAINER ELEMENT-SLV 0.255 X 0.424 IN. LONG	1	AU	PAOZZN
- 26	267625	52661	...	FLANGE-FUEL NOZ	1	AU	PAOZZN
- 27	267623	52661	...	RING-RTNG 0.156 SHAFT DIA X 0.025 IN. THK	1	AU	KD---
	500072	52661	...	PARTS KIT-REPAIR, FOR REPAIR OF 481694 FUEL NOZ	1	AU	
	663430	52661	...	NOZZLE ASSEMBLY-FUEL, REPAIR KIT 546104 AVAILABLE SUPERSEDES 518126	24	B/AV	PAFDDT
- 28	663429	52661	...	NUT-FUEL NOZ SUPERSEDES 484454	1	B/AV	PAFZZN
	520202	52661	...	NOZZLE ASSEMBLY-FUEL	1	B/AV	ADD---
	749743	52661	...	NOZZLE SET-FUEL	1	B/AV	ADD---
- 29	539512	52661	...	STRAINER ELEMENT-SLV 0.4881	1	B/AV	PADZZN
- 30	739598	52661	...	NOZZLE-FUEL	1	B/AV	PADBZN
- 31	739599	52661	...	NOZZLE-FUEL	1	B/AV	PADBZN
- 32	739597	52661	...	METERING PLUG-FUEL NOZ	1	B/AV	PADBZN
- 33	520205	52661	...	RING-RTNG 0.750 HSG DIA X 0.035 IN. THK	1	B/AV	PADZZN
- 34	267627	52661	...	SPRING-HLCPS 0.213 OD X 0.036 IN. DIA WIRE	1	B/AV	PADZZN
- 35	267626	52661	...	SUPPORT-FUEL NOZ	1	B/AV	PADZZN
- 36	520204	52661	...	RING-RTNG. FUEL NOZ	1	B/AV	PADZZN
- 37	267624	52661	...	FLANGE-FUEL NOZ	1	B/AV	PADZZN
- 38	368448	52661	...	SPRING-HLCPS 0.246 OD X 0.159 IN. DIA WIRE	1	B/AV	PADZZN
- 39	484453	52661	...	STRAINER ELEMENT-SLV 0.255 X 0.424	1	B/AV	PADZZN
- 40	267625	52661	...	FLANGE-FUEL NOZ	1	B/AV	PADZZN
- 41	520203	52661	...	RING-RTNG. FUEL NOZ	1	B/AV	PADZZN
	546104	52661	...	PARTS KIT-REPAIR, FOR REPAIR OF 518126 AND 663430 FUEL NOZ ASSY	1	B/AV	PADZZN
(42)	483264	52661	...	MANIFOLD-ASSY OF, FUEL, RIGHT	1	AS	XA---
(43)	483265	52661	...	MANIFOLD-ASSY OF, FUEL, LEFT	1	AS	XA---
- 44	348538	52661	...	SLEEVE HALF-REINFORCING, TUBE	32	AS	PADZZN
- 45	531386	52661	...	INSULATION BLANKET-FUEL MANF SUPERSEDES 336534 FOR A ENG	1	AS	XB---
- 46	531388	52661	...	INSULATION BLANKET-FUEL MANF SUPERSEDES 219224 FOR A ENG	1	AS	XB---

CONTINUED

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27				SUPERSEDES 511714 FOR A ENG			
- 47	531385	52661		...INSULATION BLANKET-FUEL MANF	3	AS	XB---
				SUPERSEDES 336535 FOR A ENG			
- 48	358279	52661		...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 49	358280	52661		...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 50	358289	52661		...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 51	358291	52661		...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 52	358203	52661		...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 53	358202	52661		...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 54	358288	52661		...SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 55	358287	52661		...SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 56	358293	52661		...SHIELD-HEAT, LEFT FUEL MANF	3	AS	PADZZN
	358293	52661		...SHIELD-HEAT, RIGHT FUEL MANF	2	AS	PADZZN
- 57	358292	52661		...SHIELD-HEAT, LEFT FUEL MANF	4	AS	PADZZN
	358292	52661		...SHIELD-HEAT, RIGHT FUEL MANF	3	AS	PADZZN
- 58	358290	52661		...SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 59	358295	52661		...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 60	358294	52661		...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 61	358206	52661		...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 62	358205	52661		...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 63	531384	52661		...INSULATION BLANKET-FUEL MANF	8	AS	XB---
				SUPERSEDES 253818			
- 64	375060	52661		...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 65	358286	52661		...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 66	375059	52661		...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 67	375057	52661		...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 68	358281	52661		...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 69	375058	52661		...SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 70	531389	52661		...INSULATION BLANKET-FUEL MANF	1	AS	XB---
				SUPERSEDES 253819 FOR A ENG			
- 71	531387	52661		...INSULATION BLANKET-FUEL MANF	3	AS	XB---
- 72	358278	52661		...SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 73	358204	52661		...SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 74	261803	52661		...FERRULE-FUEL MANF	1	AS	PADZZN
- 75	483776	52661		...SLEEVE-FUEL NOZ	24	AS	PADZZN
	563218	52661		..BRACKET AND MANIFOLD-ASSY OF, FUEL, RIGHT	1	B/AT	XA---
				SUPERSEDES 525041			
	563216	52661		..BRACKET AND MANIFOLD-ASSY OF, FUEL, LEFT	1	B/AT	XA---
				SUPERSEDES 525040			
- 76	483260	52661		...BRACKET-ASSY OF, FUEL MANF	3	B/AT	PAFBZN
- 77	303328	52661		...BOLT-MACH, DRILLED DBL HEX 0.250-28 X 0.625 IN. LONG	6	B/AT	PAFZZN
- 78	454393	52661		...NUT-PLAIN, MULTIPLE 0.250-28 X 0.560 IN. LONG	3	B/AT	PAFZZN
- 79	525041	52661		...MANIFOLD-ASSY OF, FUEL, RIGHT	1	B/AT	XA---
- 80	525040	52661		...MANIFOLD-ASSY OF, FUEL, LEFT	1	B/AT	XA---
- 81	348838	52661		...SLEEVE HALF-REINFORCING TUBE	32	B/AT	PADZZN
- 82	524324	52661		...WASHER-SHLDR 0.535 X 0.750	16	B/AT	PADZZN
- 83	531386	52661		...INSULATION BLANKET-FUEL MANF	1	B/AT	XB---
- 84	531388	52661		...INSULATION BLANKET-FUEL MANF	1	B/AT	XB---
- 85	531385	52661		...INSULATION BLANKET-FUEL MANF	3	B/AT	XB---

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27 - 86	358279	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 87	358280	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 88	358203	52661	SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
- 89	358202	52661	SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
- 90	358289	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 91	358291	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 92	358288	52661	SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 93	358287	52661	SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 94	358293	52661	SHIELD-HEAT, LEFT FUEL MANF	3	B/AT	PADZZN
	358293	52661	SHIELD-HEAT, RIGHT FUEL MANF	2	B/AT	PADZZN
- 95	358292	52661	SHIELD-HEAT, LEFT FUEL MANF	4	B/AT	PADZZN
	358292	52661	SHIELD-HEAT, RIGHT FUEL MANF	3	B/AT	PADZZN
- 96	358290	52661	SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 97	358295	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 98	358294	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 99	358206	52661	SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
-100	358205	52661	SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
-101	531384	52661	INSULATION BLANKET-FUEL MANF	8	B/AT	XB—
-102	375060	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-103	358286	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-104	375059	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-105	375057	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-106	358281	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-107	375058	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-109	531389	52661	INSULATION BLANKET-FUEL MANF	1	B/AT	XB—
-109	531387	52661	INSULATION BLANKET-FUEL MANF	3	B/AT	XB—
-110	358278	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
-111	358204	52661	SHIELD-HEAT, LEFT MANF	1	B/AT	PADZZN
-112	261803	52661	FERRULE-FUEL MANF	1	B/AT	PADZZN
-113	483776	52661	SLEEVE-FUEL NOZ	24	B/AT	PADZZN
-114	674002	52661	..	HOUSING-ASSY OF, SVCE FIX FOR REWK OF FUEL NOZ ASSY	1		
-115	674003	52661	..	HOUSING-ASSY OF, SVCE FIX FOR REWK OF FUEL NOZ ASSY	1		
-116	253759	52661	..	PROBE-PB, RIGHT FUEL MANF	1		PAFZZN
-117	AN123176	81352	..	RIVET-RIGHT FUEL MANF	1		PAFZZN
-118	515359	52661	..	SPACER-RING 0.551 X 0.755 X 0.135, SVCE FIX FOR REWK OF 483264 OR 483265 FUEL MANF ASSY	8		
-119	524324	52661	..	WASHER-SHLDR 0.535 X 0.750, SVCE FIX FOR REWK OF 483264 OR 483265 FUEL MANF ASSY	16		PADZZN
-120	457128	52661	GASKET-FUEL MANF INLET ADPTR		1		PAFZZN

DISASSEMBLY/ASSEMBLY...FILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>6-16-89</u>		ROC <u>MATPCB</u>		SHEET <u>1 of 5</u>		NAME RE MOVED ITEM INSTALLED INFO ASST. Y/N
TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY					
ITEM NUMBER	WCB	WCD DATE			ITEM NUMBER	CHLO WCD	CHLO WCD DATE			
PCN 98034A 98043A NSH PIN 98042A 98057A	CBEC04	88097	55	290	PCN 358279 NSH PIN	98034A 98043A 98042A 98057A S1				
PCN NSH PIN					PCN 35820 NSH PIN	S2				
PCN NSH PIN					PCN 35829 NSH PIN	S3				
PCN NSH PIN					PCN 358291 NSH PIN	S4				
PCN NSH PIN					PCN 358203 NSH PIN	S5				
PCN NSH PIN					PCN 358202 NSH PIN	S6				
PCN NSH PIN					PCN 358288 NSH PIN	S7				
PCN NSH PIN					PCN 358287 NSH PIN	S8				
PCN NSH PIN					PCN 358293 NSH PIN	S9				
PCN NSH PIN					PCN 358293 NSH PIN	S10				
PCN NSH PIN					PCN 358292 NSH PIN	S11				
PCN NSH PIN					PCN 358292 NSH PIN	S12				

DISASSEMBLY/ASSEMBLY ... FILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>6-16-89</u>		DOC <u>MA7PCB</u>		SHEET <u>2 of 5</u>	
TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			NAME IN MOVING ITEM INSTALLED INTO ASST. VIN	
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHKD WCD	CHKD WCD DATE		
PCN 98034A 98043A NSM 98042A 98057A PIN	CBEC04	88097	55	290	PCN 358290 NSM PIN	98034A 98043A 98042A 98057A S19			
PCN NSM PIN					PCN 358295 NSM PIN	S14			
PCN NSM PIN					PCN 358294 NSM PIN	S15			
PCN NSM PIN					PCN 358206 NSM PIN	S16			
PCN NSM PIN					PCN 358205 NSM PIN	S17			
PCN NSM PIN					PCN 375060 NSM PIN	S18			
PCN NSM PIN					PCN 358286 NSM PIN	S19			
PCN NSM PIN					PCN 375059 NSM PIN	S20			
PCN NSM PIN					PCN 375057 NSM PIN	S21			
PCN NSM PIN					PCN 358281 NSM PIN	S22			
PCN NSM PIN					PCN 375058 NSM PIN	S23			
PCN NSM PIN					PCN 358278 NSM PIN	S24			

LSC-210713A

DISASSEMBLY/ASSEMBLY ...FILE

NAME PHUNT ALC OC DATE 6-16-87 RDC MAIPCB SHEET 3 of 5

TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			SAME REMOVED ITEM INSTALLED INTO ASST. TIN
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHRO WCD	CHRO WCD DATE	
PCN 98034A 98043A NSH 98042A 98057A PIN	CBEC04	88097	55	290	PCN 98034A 98043A NSH 98042A 98057A PIN	525		
PCN NSH PIN					PCN 483776 NSH 52661 PIN	526		
PCN NSH PIN					PCN 563216 NSH 52661 PIN	527		
PCN NSH PIN					PCN 483260 NSH PIN	528		
PCN NSH PIN					PCN 525041 NSH PIN	529		
PCN NSH PIN					PCN 525040 NSH PIN	530		
PCN NSH PIN					PCN 358229 NSH PIN	531		
PCN NSH PIN					PCN 358280 NSH PIN	532		
PCN NSH PIN					PCN 358203 NSH PIN	533		
PCN NSH PIN					PCN 35802 NSH PIN	534		
PCN NSH PIN					PCN 358289 NSH PIN	535		
PCN NSH PIN					PCN 358291 NSH PIN	536		

LSC-20MPSA

DISASSEMBLY/ASSEMBLY ... FILE

NAME <u>PHUNT</u>		AIC <u>OC</u>		DATE <u>6-16-87</u>		ROC <u>MA7PCB</u>		SHEET <u>4 of 6</u>	
TOP ASSEMBLY				SUBASSEMBLY		ITEM NUMBER		CHLD WCD	
ITEM NUMBER	WCD	WCD DATE	REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	ITEM NUMBER	CHLD WCD	CHLD WCD DATE	NAME AS MOVED NEW INSTALLED INTO ASST	
PCN 98034A 98043A NSH PIN 98042A 98057A	CBEC04	88097	55	290	PCN 358288 NSH PIN	98034A 98043A 98042A 98057A	537		
PCN NSH PIN					PCN 358287 NSH PIN		538		
PCN NSH PIN					PCN 358293 NSH PIN		539		
PCN NSH PIN					PCN 358293 NSH PIN		540		
PCN NSH PIN					PCN 358292 NSH PIN		541		
PCN NSH PIN					PCN 358290 NSH PIN		542		
PCN NSH PIN					PCN 358295 NSH PIN		543		
PCN NSH PIN					PCN 358294 NSH PIN		544		
PCN NSH PIN					PCN 358206 NSH PIN		545		
PCN NSH PIN					PCN 358205 NSH PIN		546		
PCN NSH PIN					PCN 375060 NSH PIN		547		
PCN NSH PIN					PCN 358286 NSH PIN		548		

DISASSEMBLY/ASSEMBLY ...FILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>6-16-89</u>		DOC <u>MA7PCB</u>		SHEET <u>5 of 5</u>	
TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			NAME OF MOVED ITEM INSTALLED DATE	
ITEM NUMBER	WCD	WCD DATE			CHRD WCD	CHRD WCD DATE			
PCN 98034A 98043A NSH 98042A 98057A PIN	CBEC04	88097	55	290	PCN NSH PIN	375054	98034A 98043A 549 98042A 98057A		
PCN NSH PIN					PCN NSH PIN	375057	550		
PCN NSH PIN					PCN NSH PIN	358281	551		
PCN NSH PIN					PCN NSH PIN	375058	552		
PCN NSH PIN					PCN NSH PIN	358278	553		
PCN NSH PIN					PCN NSH PIN	358204	554		
PCN NSH PIN					PCN NSH PIN				
PCN NSH PIN					PCN NSH PIN				
PCN NSH PIN					PCN NSH PIN				
PCN NSH PIN					PCN NSH PIN				
PCN NSH PIN					PCN NSH PIN				
PCN NSH PIN					PCN NSH PIN				
PCN NSH PIN					PCN NSH PIN				
PCN NSH PIN					PCN NSH PIN				

NAME E. TOTTER		ALC OC		DATE 5/7/69		RCC MATRB		SHEET 0 OF 4						
ITEM CODE NON PIN		PCD 98034A, 98042A, 98043A, 98057A		WCD CTEC04		WCD DATE 8/7/10								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED %	HRS.	DATA SOURCE COMMENTS	
							QTY.	%	QTY.	EQUIPMENT CODE				
050	MAT PCB	P2LOC	1.0	TEST CHECK PROCESS	0.2	0P09	001	100	0.2	OC 1132	001	100	0.2	REMOVE PROTECTIVE CAPS
060		P2LOC	1.0	TEST CHECK PROCESS	0.02			100	0.02				0.02	OF UC 1133 INSTALL CLAMPS ON NOZZLES
070		TEST	1.0	TEST CHECK PROCESS	0.02			100	0.02				0.02	PERFORM NOZZLE SPRAY TESTS; FLOW & PRESSURE MONITORING; THAN PRIMARY; (ASSUME NO FAIL IF INK INITIAL CAPSON NEW NOZZLE(S))
080		TEST	1.0	TEST CHECK PROCESS	0.12			100	0.12				0.12	PERFORM INTERNAL LEAK TEST. IF FAIL FOR OTHER THAN NOZZLE RETURN REJECTED TO SUPPLIER. IF NOzzle FAIL GO TO 120.
090		TEST	1.0	TEST CHECK PROCESS	0.2			100	0.2				0.2	PERFORM EXTERNAL LEAK TEST. IF NOZZLE FAIL, GO TO 120.

OPERATION PROFILE

NAME <u>E. TOTTER</u>		ALC <u>OC</u>		DATE <u>5/9/89</u>		RCC <u>MATLAB</u>		SHEET <u>3</u> OF <u>4</u>				
ITEM CODE <u>PCD 98034A, 98042A, 98043A, 98057A</u>		WCD <u>CTEC04</u>		WCD DATE <u>8/7/10</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED HRS.	DATA SOURCE COMMENTS
							QTY.	%	QTY.	%		
100	MBT PB	PROC	1.0	TEST	0.02	A109	001	100	0.02	001	100	REMOVE NOZZLE CLAMPS
				STOP								
				PROCESS								
110		PROC	.8	TEST	0.05			100	0.05		10	BARE FACE NOZZLE SEALS IF INTERNAL LEAK TEST FAILED. (ISOLATE LEAKING NOZZLES.)
				STOP	3.5			98.5	3.5			
				PROCESS	6.0			0.5	6.0			
120		REPL	.80	TEST	0.05			100	0.05		100	REPLACE NOZZLE AND SEAL IF SPRAY TEST INTERNAL OIL EXTERNAL LEAK TEST FAILS AND NOZZLE IS CAUSE.
				STOP								
				PROCESS								
130		CLEAN	1.0	TEST	0.8			100	0.8		100	OIL FLUSH MANIFOLD - REMOVE RESIDUAL FUEL
				STOP								
				PROCESS								
140		PROC	1.0	TEST	0.01			100	0.01		100	INSTALL HEAD GASKET FOR TRANSIT.
				STOP								
				PROCESS								

(TIME TO REPLACE SINGLE NOZZLE)

OPERATION PROFILE

NAME E. TOTTEN ALC OC DATE 5/7/89 RCC MATRB SHEET 4 OF 4

ITEM CODE 98034A 98034A, WCD CTEC04 WCD DATE 8/7/80

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
150	MAT RB	UNLD	1.0	TRANSIT	0.01	009	001	100 0.01				REMOVE MANIFOLD FROM TEST STAND AND PLACE ON CART.
160		(P)	1.0	TRANSIT	0.05			100 0.05				COMPLETE MARKING
170		MOVE	1.0	TRANSIT	0.1			50 0.1				MOVE MANIFOLD TO PICK UP AREA IN BLDG 3108 (MANIFOLD) PLACE ON CART.
9999		OUT DATE	1.0	TRANSIT	0.2			50 0.2				
				SETUP								
				PROCESS	36							
				TRANSIT								COMMENT: SEVERAL TIMES DURING OPERATION OPERATOR MUST SHUT OFF AND ON AIR OF FLOW AT TEST STAND
				SETUP								
				PROCESS								

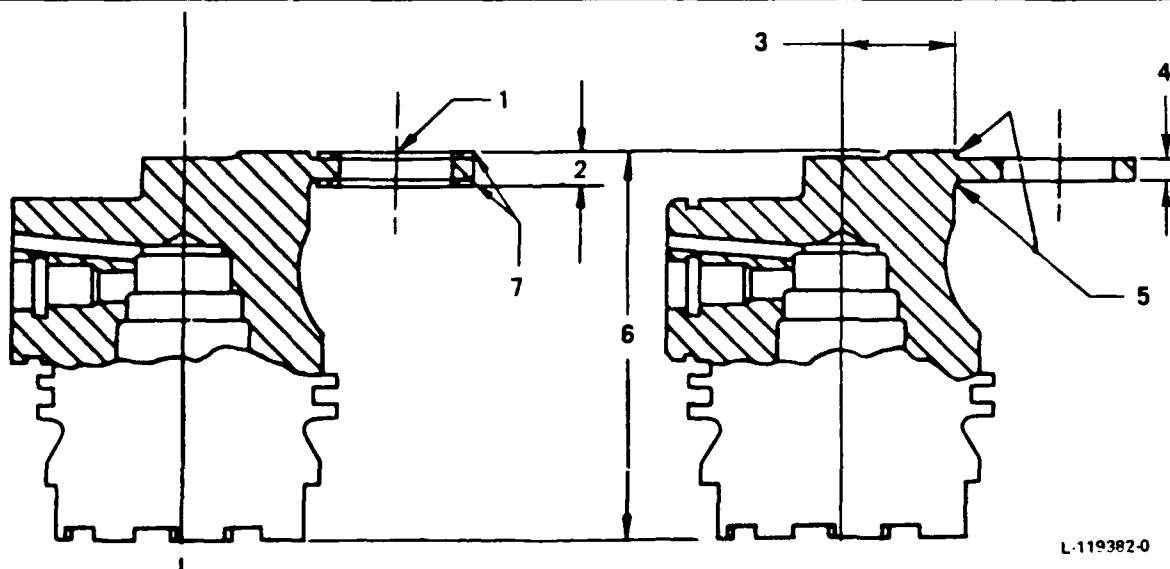
NAME KOBYLIK ALC OC-ALC DATE 017UN89 ROC MATCBL SHEET OF

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LSC: 20075A

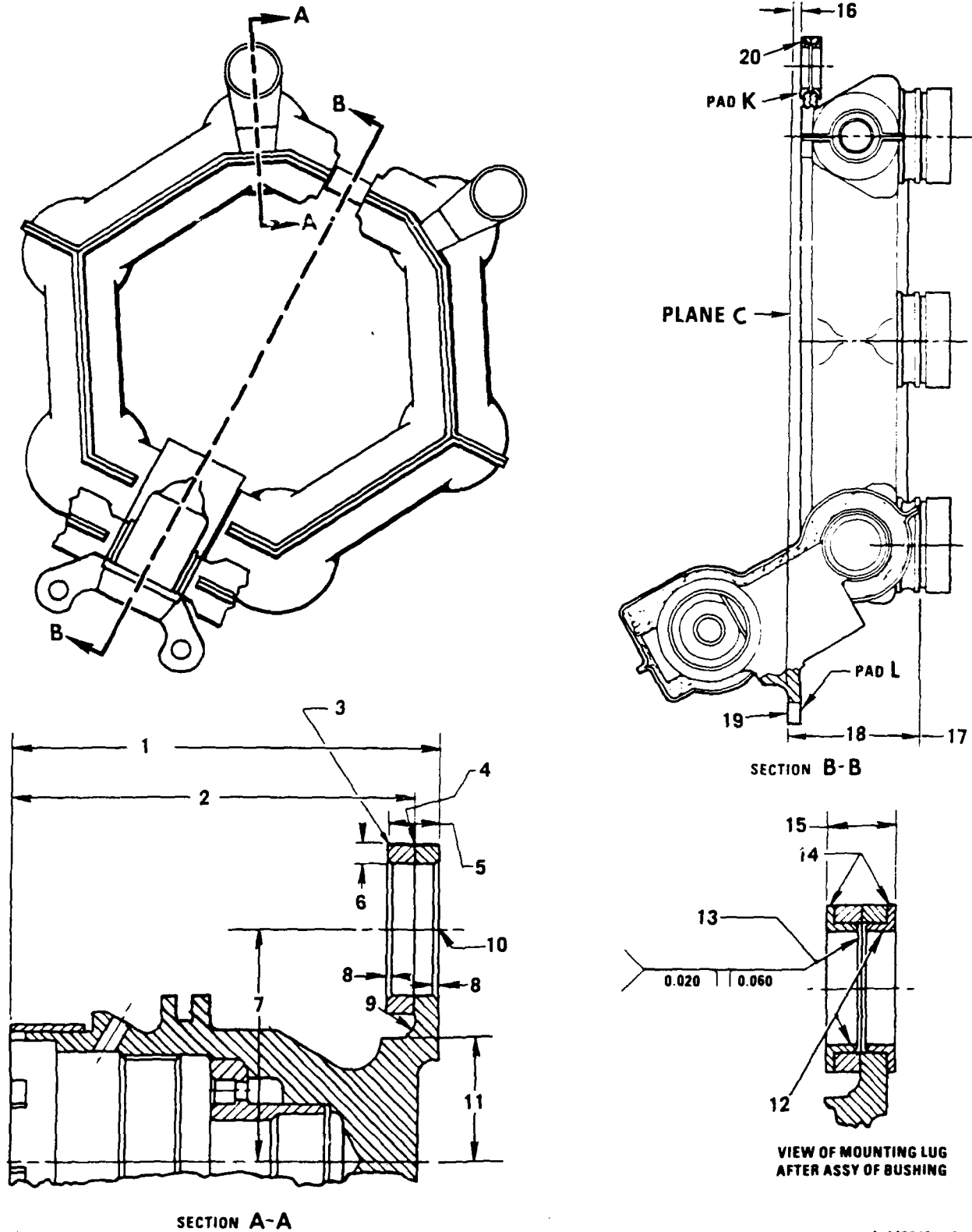
TABLE 2. FUEL MANIFOLD DISTORTION LIMITS

Location Measurement	Acceptable As Is	Cold Bend	Cold Bend and Stress-relief
Inner nozzle cluster lugs to mounting surface	0.188 inch	0.312 inch	0.750 inch
Variations between inner lugs of each cluster	0.094 inch	0.219 inch	0.281 inch
Outer nozzle cluster lugs to mounting surface	0.062 inch	0.188 inch	0.250 inch
Variations between outer nozzle cluster lugs on each cluster	0.094 inch	0.156 inch	0.219 inch
Nozzle bodies to mounting lugs	0° 45'	1° 30'	-
Distance A. (See figure 3.)	20.160 ±0.500 inch	20.160 ±0.625 inch	20.160 ±2.000 inch
Distance B. (See figure 3.)	11.615 ±0.060 inch	11.615 ±0.185 inch	11.615 ±0.375 inch
Inner lug hole centers alignment with fixture holes	0.094 inch	0.156 inch	0.188 inch
Outer lug hole centers alignment with fixture holes	0.031 inch	0.062 inch	-
Misalignment of inlet flange with fixture	0.080 inch	0.080 - 0.160 inch	0.160 - 0.375 inch



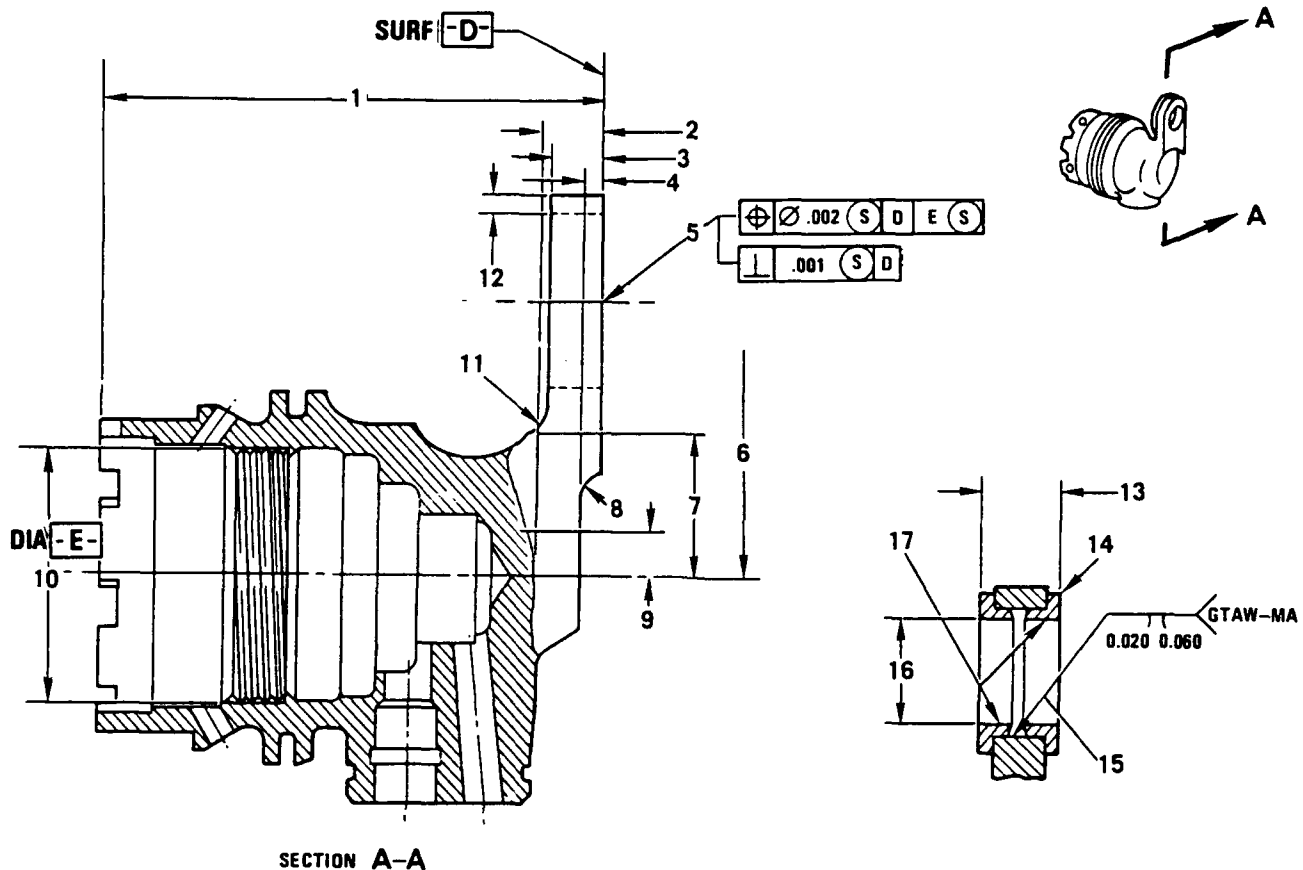
- | | |
|---|---|
| 1. 0.542 - 0.552 inch diameter through hole | 0.150 - 0.157 inch for hardface buildup |
| 2. 0.177 - 0.181 inch | 5. 0.016 - 0.047 inch radius |
| 3. 0.550 - 0.570 inch | 6. 1.945 - 1.955 inches |
| 4. 0.060 - 0.070 inch for parent metal buildup; | 7. Weld build up (hardface overlay) |

Figure 5. Worn Inner Mounting Lug - Inspection and Repair



L-118010-0 (53 X 2)

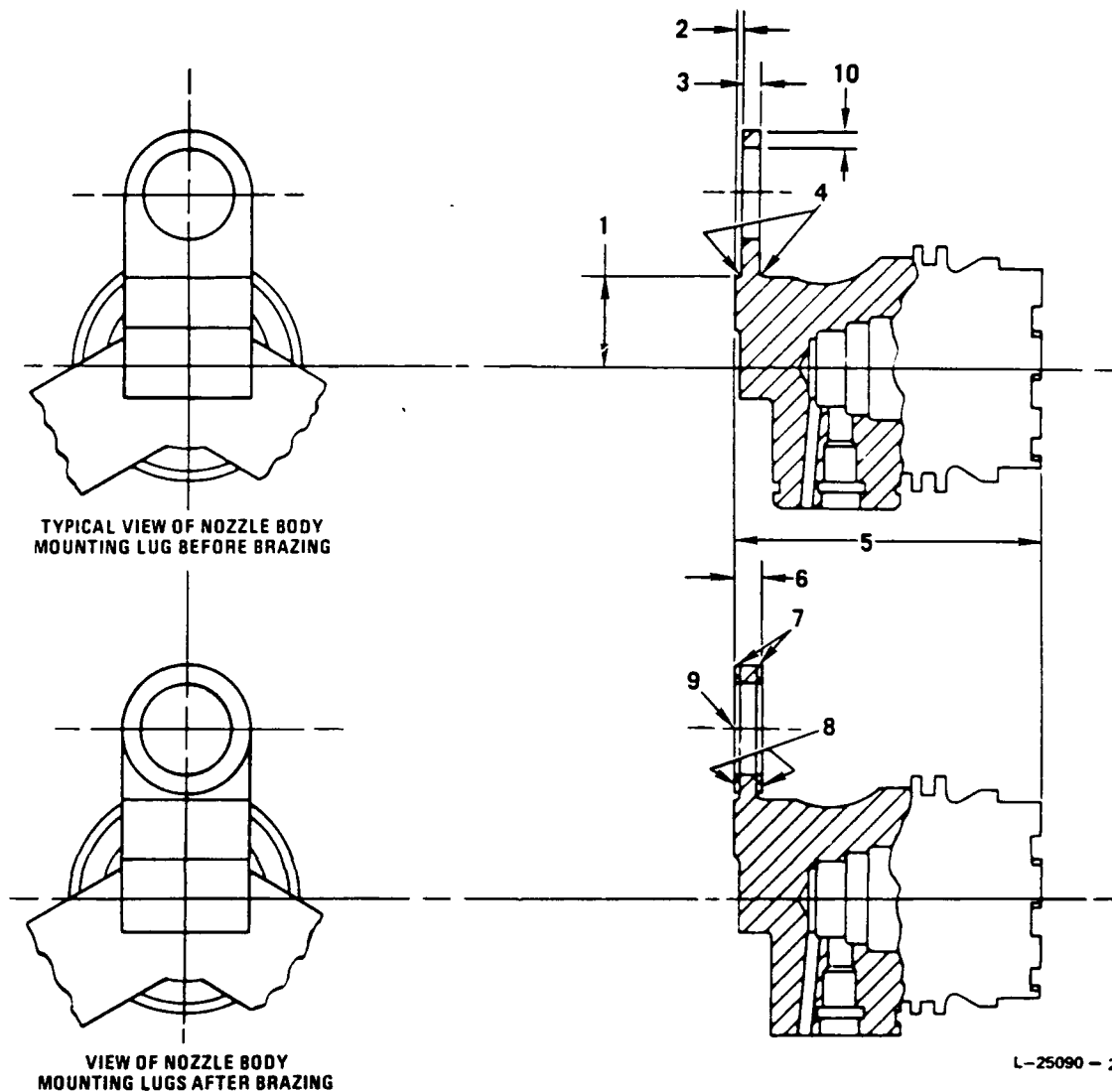
Figure 6. Inner Mounting Lug Bushings Incorporating Spacer - Inspection and Repair



L-18846-1 (32X2)

- | | |
|---|---|
| 1. 1.912 to 1.918 inches | 10. Pitch diameter of threads |
| 2. 0.235 to 0.255 inch | 11. 0.047 to 0.078 inch radius |
| 3. 0.229 to 0.231 inch | 12. 0.050 inch minimum thickness (P-7A, PW-100A); |
| 4. 0.075 to 0.095 inch | 0.070 inch minimum thickness (P-3, -5, -9, -11A, PW-102, -102A, -103) |
| 5. 0.5935 to 0.5945 inch diameter through. Chamfer 90° ±2° inclusive to 0.620 to 0.640 inch diameter, both sides. | 13. 0.295 to 0.305 inch |
| 6. 1.038 inches | 14. PN 524324 bushing, 16 required |
| 7. 0.550 to 0.570 inch | 15. Two places, 180° ±5° apart |
| 8. 0.047 to 0.078 inch radius | 16. 0.520 inch minimum diameter through |
| 9. 0.150 inch gage | 17. Weld shall not extend above these surfaces. |

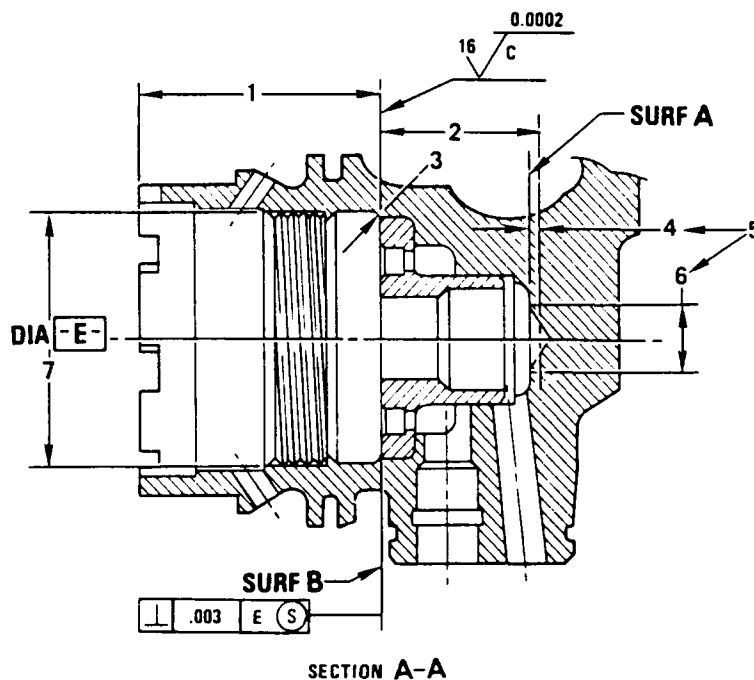
Figure 7. Inner Mounting Lug Bushings Not Incorporating Spacers - Inspection and Repair



1. 0.550 to 0.570 inch
2. 0.025 to 0.035 inch
3. 0.115 to 0.125 inch
4. 0.016 to 0.047 inch
5. 1.945 to 1.955 inches
6. 0.177 to 0.181 inch

7. Braze area.
8. Reinforcing plate located within 0.010 inch of true position
9. 0.542 to 0.552 inch diameter through hole
10. 0.050 inch minimum thickness

Figure 8. Inner Mounting Lugs Incorporating Reinforcing Plate - Inspection and Repair



60929-2 (26X2)

- | | |
|---|---|
| 1. 0.937 inch maximum after finishing.
Maintain 0.906 inch minimum diameter. | 5. After finishing Surface B, machine Surface A
within these limits, as required, to maintain
dimension(2). |
| 2. 0.568 inch minimum | 6. 0.220 to 0.240 inch diameter |
| 3. 0.005 to 0.015 inch modified radius | 7. Pitch diameter of threads |
| 4. 0.015 inch maximum | |

Figure 11. Fuel Manifold Nozzle Body Seal Seat - Repair

- (2) Complete lapping using PWA 8575 lap tool and Corundum 302 1/2E grit lapping compound, or equivalent. Restore original surface finish to Surface B per figure 11.
- (3) Check Surface B using AF 7825139 air gage spindle and AF 7825140 master gage assembly or AF 8147845 dial indicator.
- (4) Relap if Surfaces A and B are not in same plane within 0.0005 inch.
- (5) If seal depth(1, figure 11) exceeds 0.932 inches, tap nozzle body per paragraph 27 and add additional thread to nozzle body threads.
- (6) After final lapping, clean and flush manifolds per paragraphs 5 and 6.

14. WORN NOZZLE BODIES (WITH SLEEVES REMOVED) - REPAIR. (See Figures 12 through 14.)

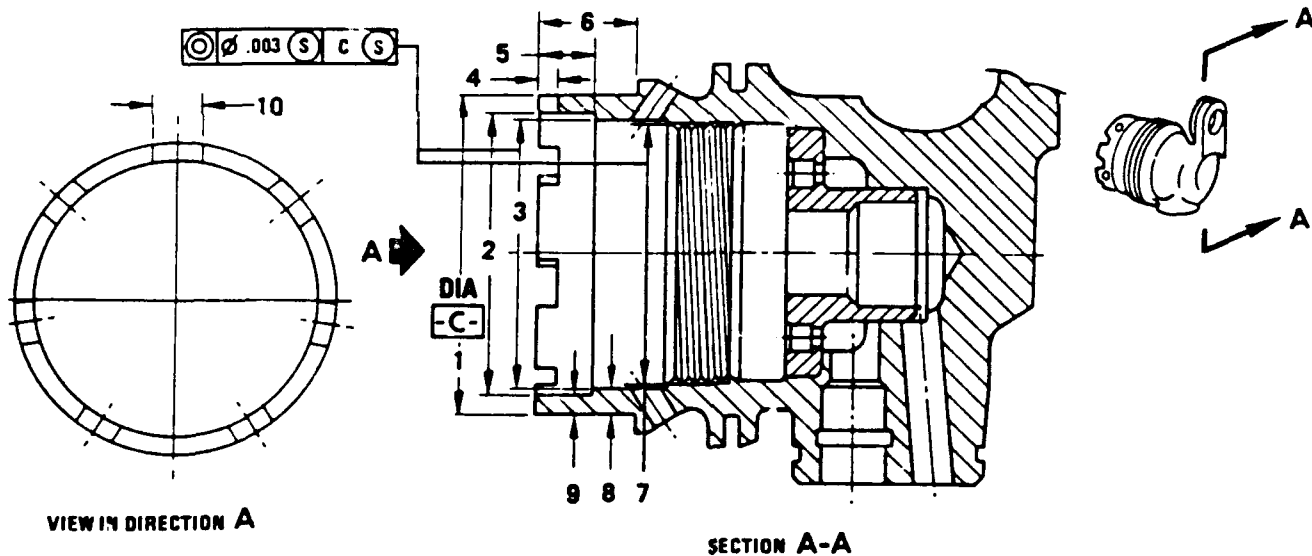
CAUTION

Prevent entry of dirt, machine chips, and other foreign materials into manifold.

NOTE

This procedure shall be used for all parts exceeding wear limits per figure 12.

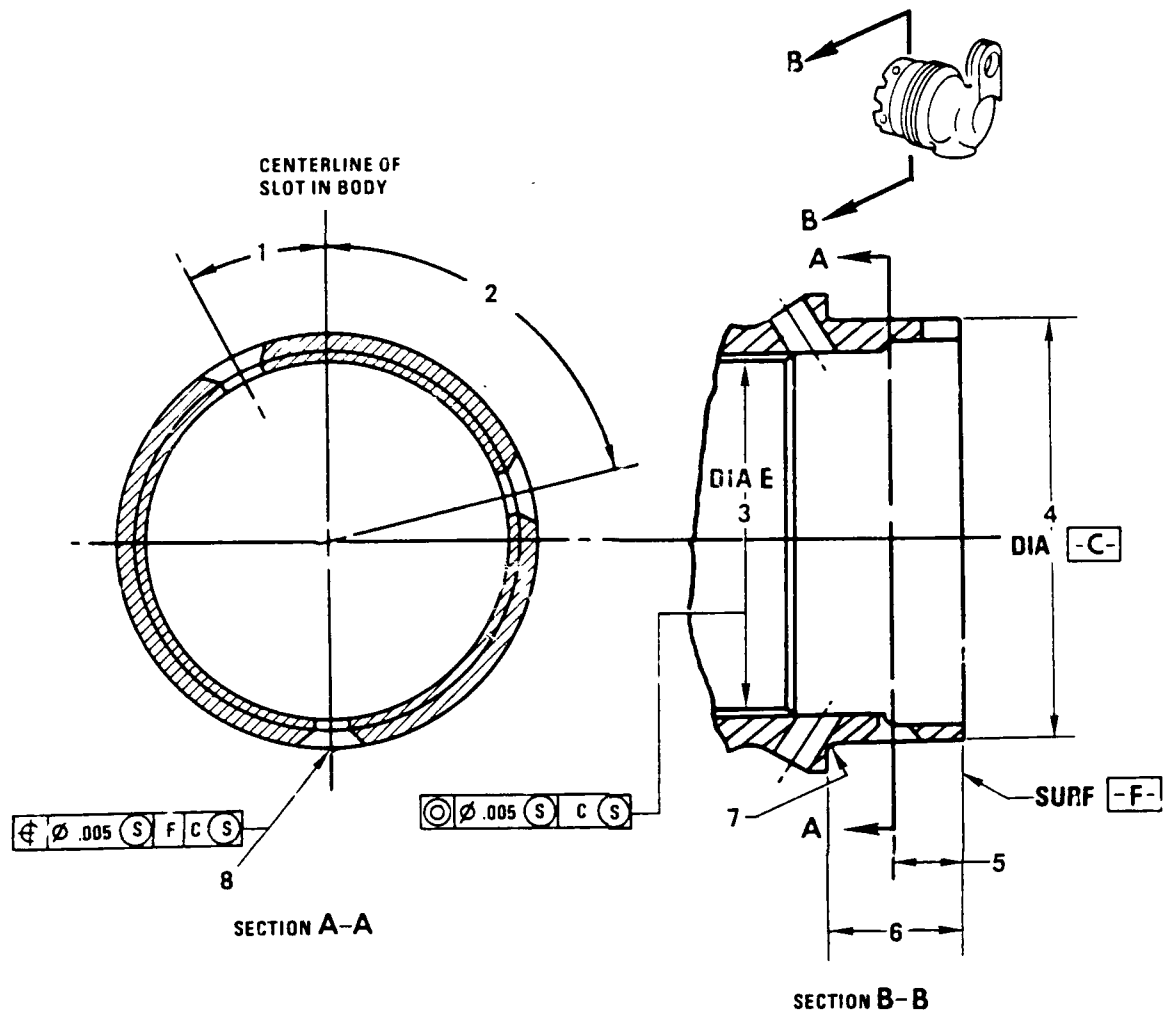
- a. Clamp PWA 16667 holding fixture to base of radial drill, or equivalent. Spindle of machine shall be equipped with locking floating tool holder.



L-33516-2 (20X2)

- | | |
|----------------------------------|--|
| 1. 1.160 to 1.161 inch diameter | 7. Pitch diameter of threads |
| 2. 1.070 to 1.080 inch diameter | 8. 0.080 to 0.091 inch |
| 3. 1.010 to 1.014 inch diameter | 9. 0.040 inch minimum wall thickness |
| 4. 0.070 to 0.080 inch, 7 places | 10. 0.176 to 0.180 inch. 7 slots equally spaced and located within 0.005 inch either side of true position in relation to diameter(2). Angular relation to features not important. |
| 5. 0.210 to 0.220 inch | |
| 6. 0.358 to 0.362 inch | |

Figure 12. Nozzle Body Outside Diameter - Repair

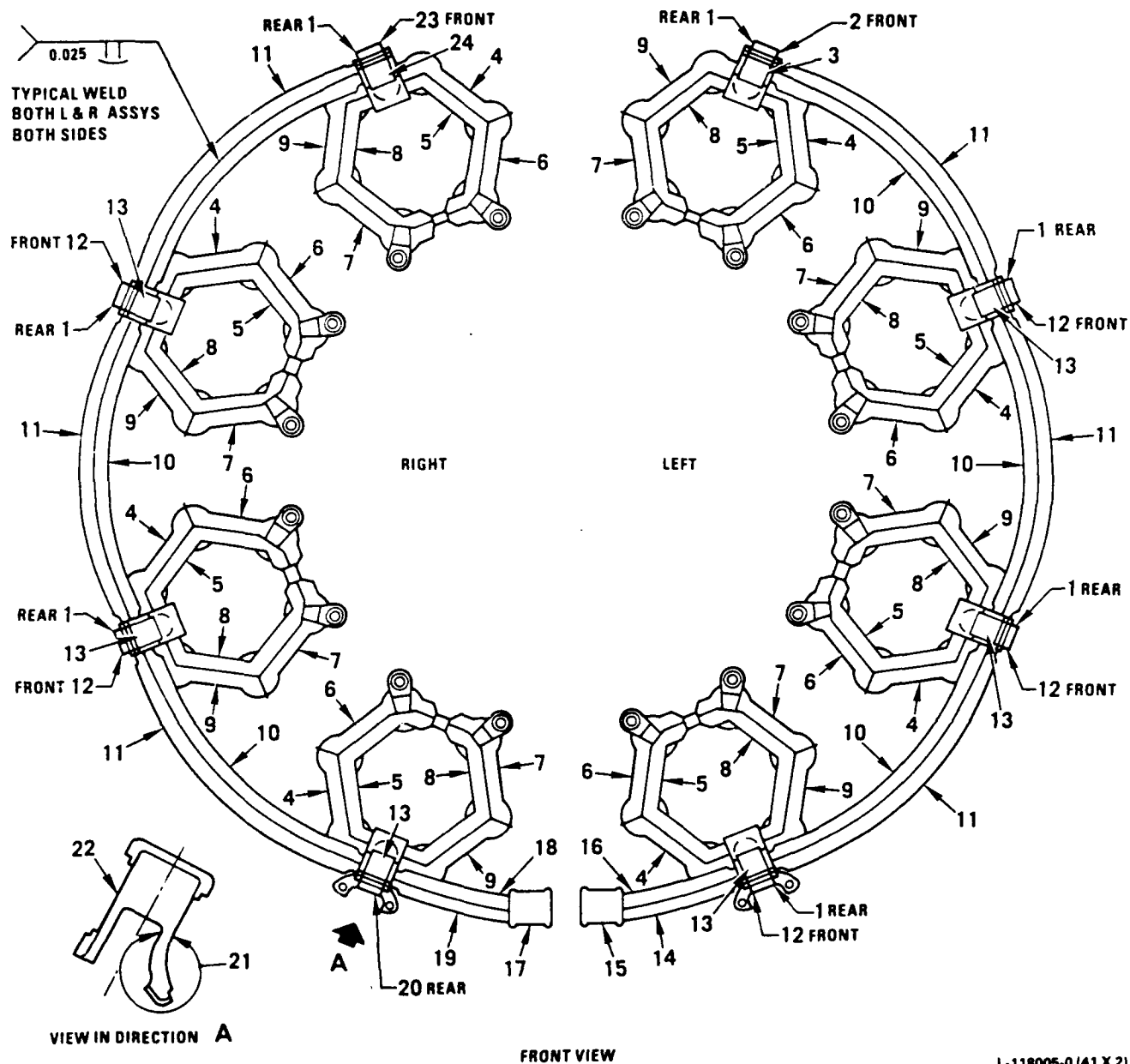


L-24368-1 (36 X 2)

1. $25^{\circ} 43'$
2. $77^{\circ} 9'$
3. 1.00 - 28 NS thread, 0.9790 inch pitch diameter
4. 1.160 - 1.161 inch diameter
5. 0.200 inch
6. 0.358 - 0.362 inch

7. 0.005 - 0.020 inch radius
8. Three holes, equally spaced and located as shown. 0.136 - 0.146 inch diameter through. Chamfer $90^{\circ} \pm 5^{\circ}$ to 0.178 - 0.198 inch diameter.

Figure 13. Nozzle Body Outside Diameter - Repair

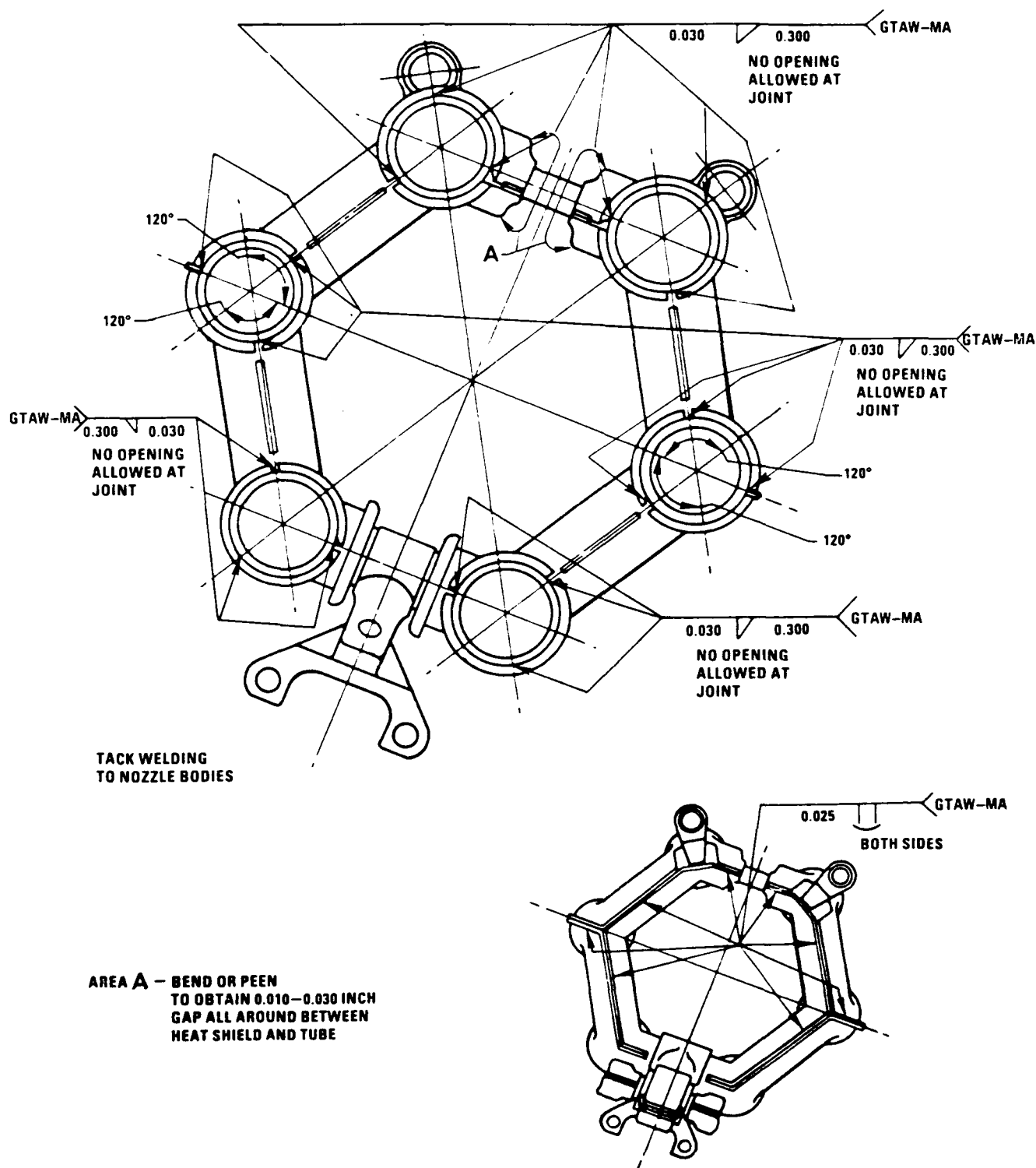


L-118005-0 (41 X 2)

Figure 15. Location of Fuel Manifold Heat Shields

Legend to figure 15

Heat Shield Part No.	Units Per Right Manifold and Nozzle Assembly	Units Per Left Manifold and Nozzle Assembly
1. 358292	3	4
2. 358205	0	1
3. 358206	0	1
4. 358286	4	4
5. 375060	4	4
6. 375059	4	4
7. 375058	4	4
8. 375057	4	4
9. 358281	4	4
10. 358288	3	3
11. 358287	3	3
12. 358293	2	3
13. 358290	3	3
14. 358202	0	1
15. 358204	0	1
16. 358203	0	1
17. 358278	1	0
18. 358279	1	0
19. 358280	1	0
20. 358289	1	0
21. Enclosed area may be twisted 90° counter- clockwise to allow assembly of heat shield. Twist back after assembly.		
22. 358291	1	0
23. 358294	1	0
24. 358295	1	0



L-22489-1 (53 X 2)

Figure 16. Welding of Clusters (Typical) Eight Places

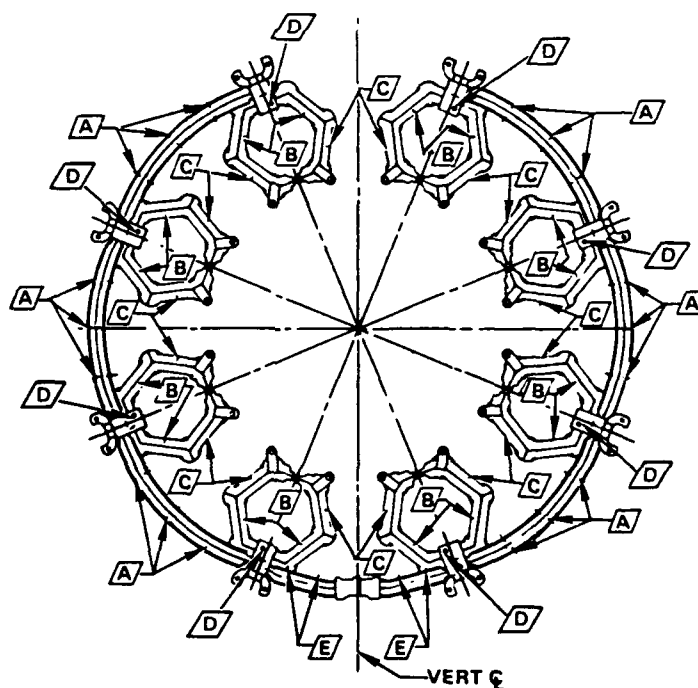
CAUTION

- Due to variations in heat shields and fuel line details and because of distorted or dented heat shields, caution shall be taken in drilling holes. Refer to assembly drawing when in doubt. Holes may deviate from this drawing only to avoid hitting fuel lines.
 - After drilling, examine fuel tubes through hole to ensure tube has not been damaged.
- (2) Secure manifold to PWA 6983, PWA 8376 or PWA 17921 fixture. Drill holes in manifold shielding as shown in figure 18, Sheets 1 through 3. Drill only to depth required.

- (3) Use PWA 407 sealant (DC 93-118) to insulate and seal heatshields.

NOTE

- Any manifold that shows evidence of chemical residue before or during the injection of the insulating sealant shall be flushed with water and air before injection continues. (See paragraph 6.)
 - If sealant already injected into any area is disturbed by water or air flushing, the area can be reinjected.
- (4) Inject insulating sealant at 50 to 60 psig in sequence per figure 18 using air-powered sealant gun, Semco Model 250, or equivalent, with plastic nozzle cut to accommodate diameter of holes.



TYPICAL FRONT VIEW
OF LEFT & RIGHT MANIFOLD ASSEMBLY L-43943-1 (26 X 2)

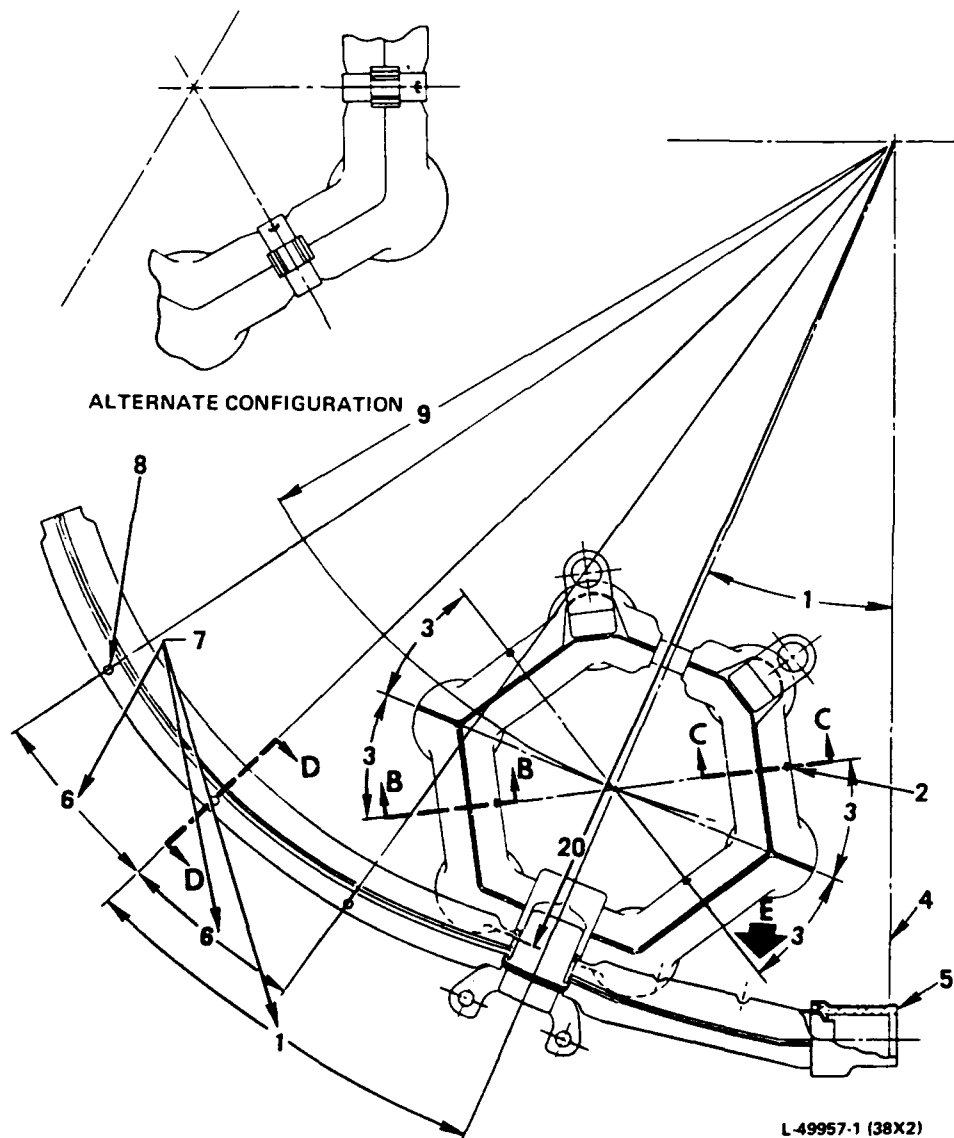
Figure 18. Fuel Manifold Heat Shield Insulation - Installation (Sheet 1)

- (5) Inject sealant until it extrudes from crevices at end of shielding and adjacent hole, or until no voids are evident. Repeat procedure for each segment or cluster of shielding.
- (6) Cure manifold assembly in oven at 350° - 400°F (177° - 204°C) for minimum of 20 minutes.

NOTE

Heat shield openings may be welded closed if necessary.

- (7) Remove all protruding sealant from openings and exterior of manifold.
- g. Repaired manifolds shall meet all test requirements of paragraph 34.



L-49957-1 (38X2)

Figure 18. Fuel Manifold Heat Shield Insulation - Installation (Sheet 2)

- i. Grind or machine per T.O. 2J-TF33-53-1, WP 013 00 to remove slight bulges in manifold to manifold mating faces caused by installation of bushings.
- j. Use corundum 302 1/2E lapping compound and lap manifold adapters as necessary per T.O. 2J-TF33-53-1, WP 013 00 to obtain surface finish and flatness requirements per figure 19.

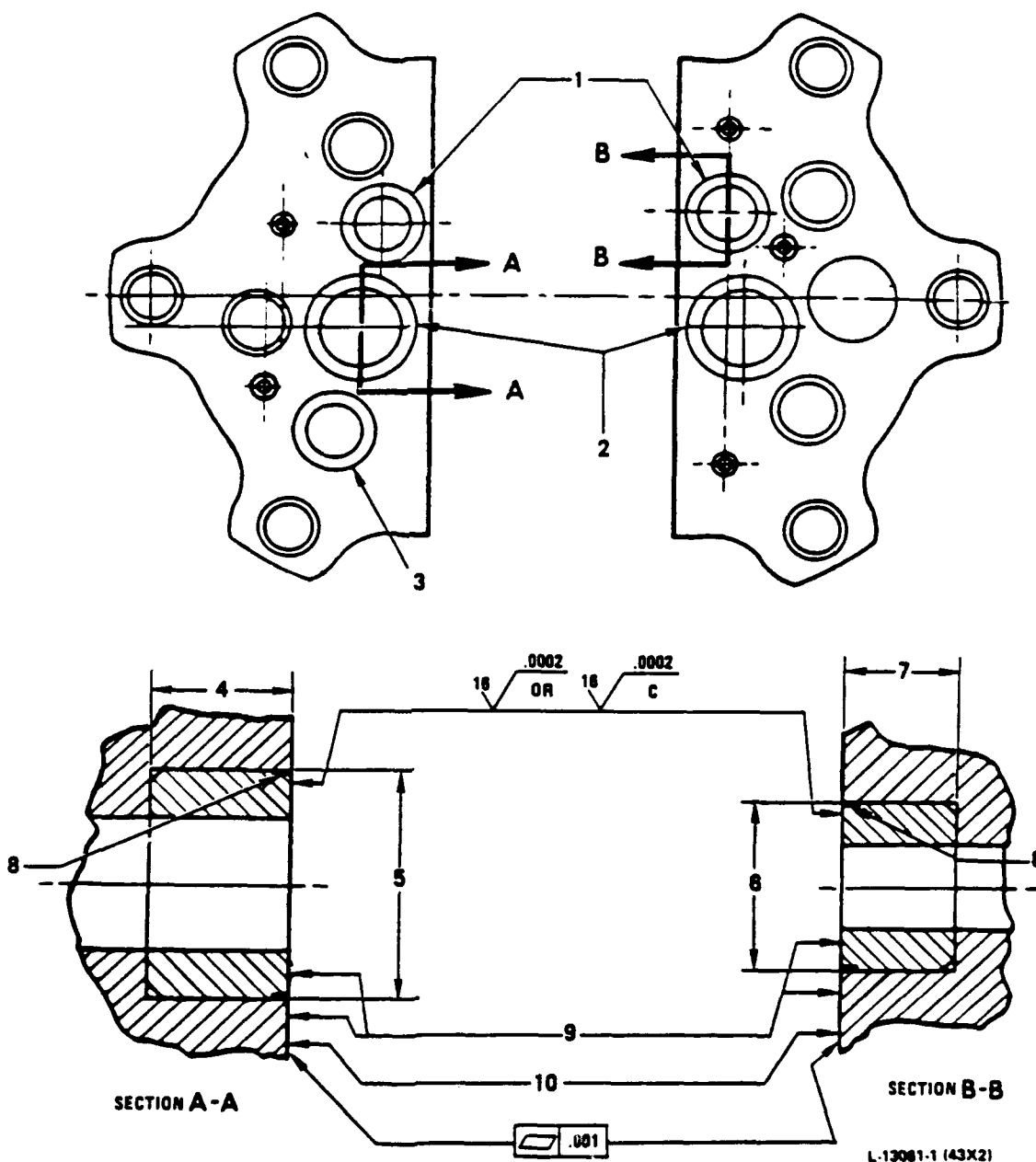
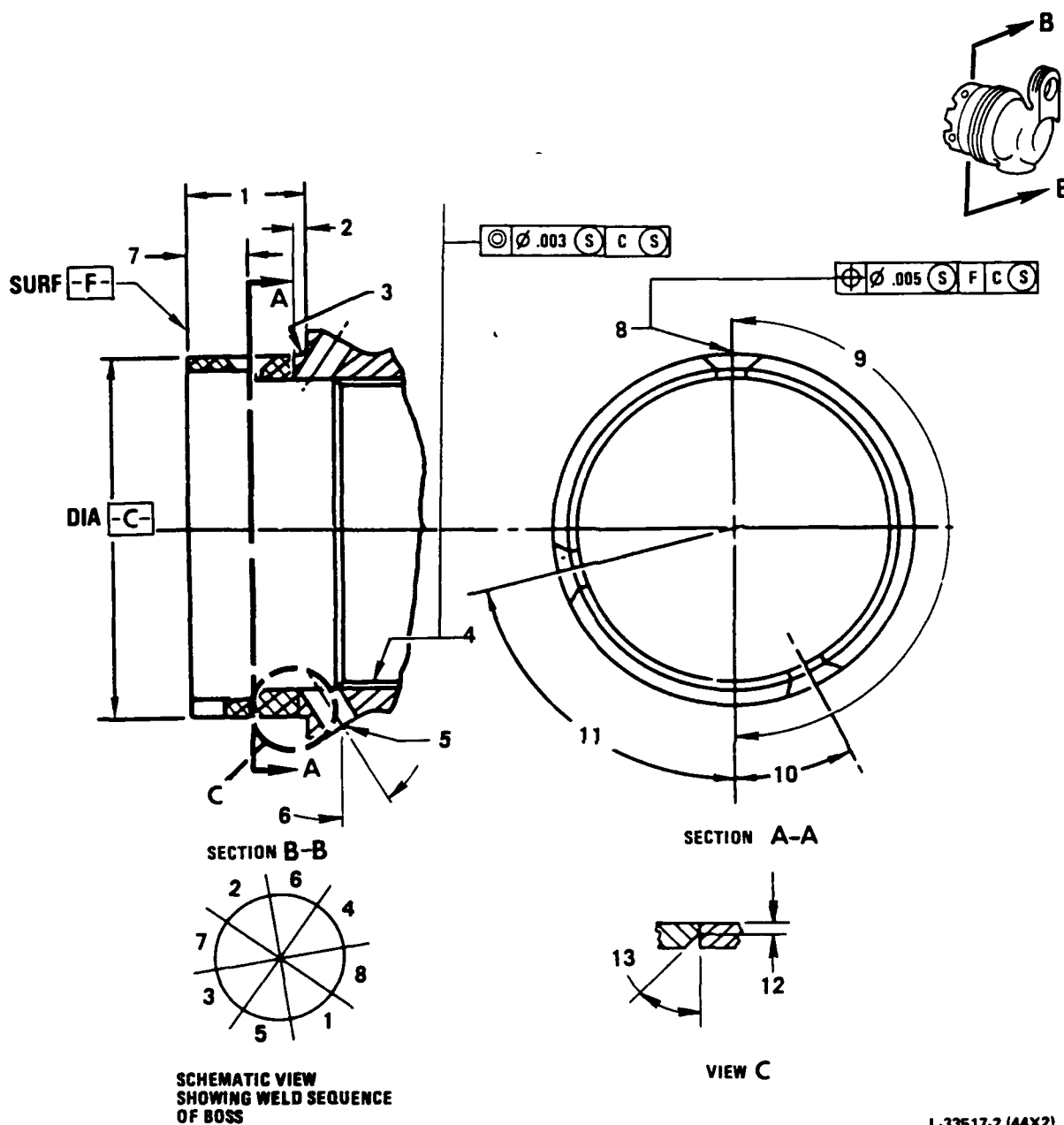


Figure 19. Inlet Adapter Bushing - Repair and Replacement



L-33517-2 (44X2)

1. 0.358 - 0.362 inch
2. 0.060 inch minimum
3. 0.031 - 0.047 inch radius
4. 1.000-28NS thread, 0.9790 inch PD
5. 0.111 - 0.116 inch diameter. 20 holes
6. $35^\circ \pm 1^\circ$
7. 0.200 inch
8. Three holes equally spaced and located as shown.

9. 180 degrees from centerline of slot
10. $25^\circ 43'$
11. $77^\circ 9'$
12. 0.030 - 0.050 inch
13. $45^\circ \pm 5^\circ$

Figure 20. Nozzle Body Boss - Repair and Replacement

29. FUEL MANIFOLD INLET ADAPTER - REPAIR. (See Figure 21.)

- a. Reject part if manifold inlet flange grinding repairs result in flange plate finished thickness less than 0.260 inch.

NOTE

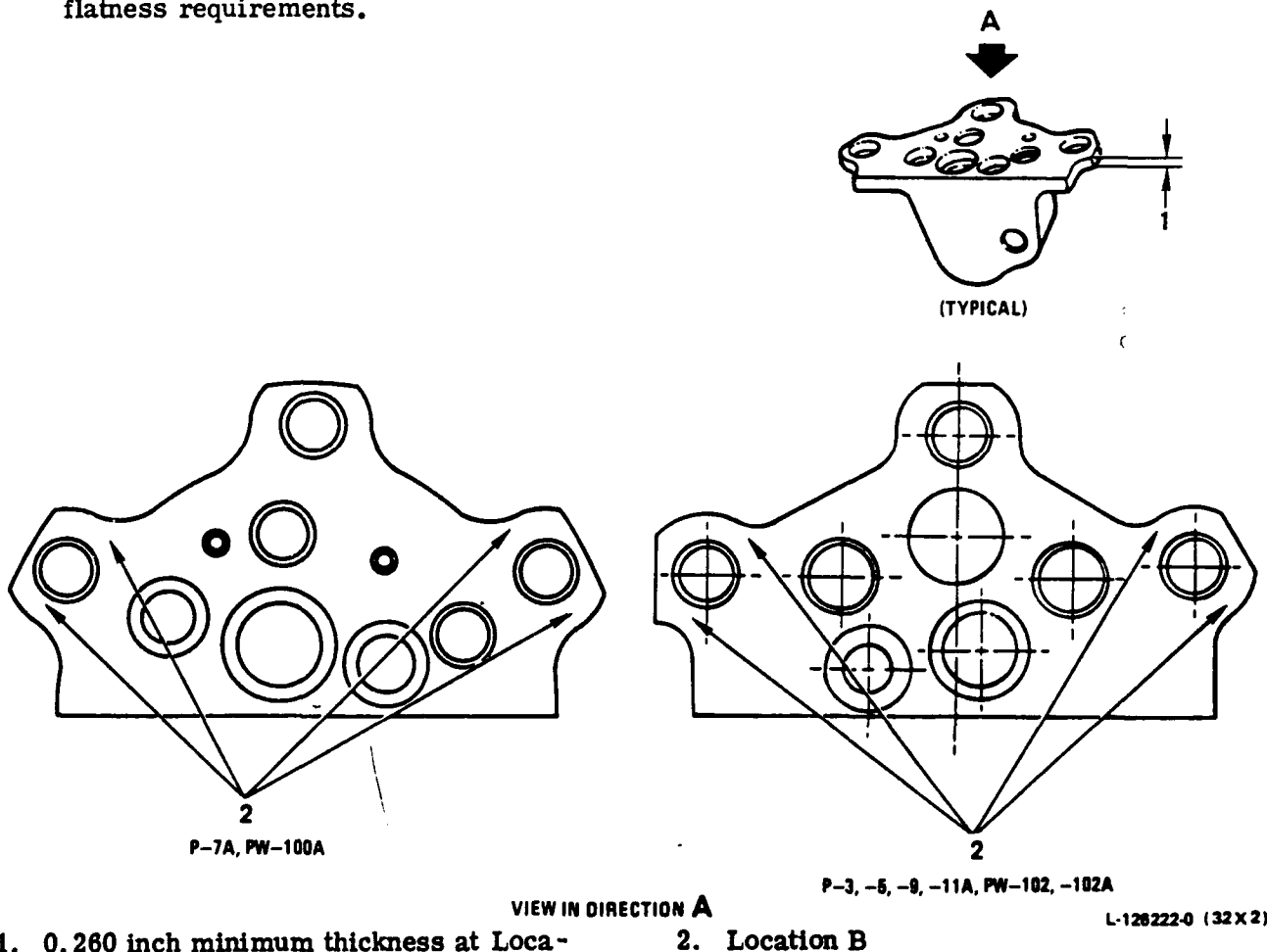
Flange measurements shall be made adjacent to diffuser case outer bolt-holes. Surfaces shall be free of defects, raised or irregular material or casting number, etc. that affect measurements. (See figure 21.)

Any surface pits, chips, or voids are permissible if removable while grinding or lapping manifold adapter to the required surface finish and flatness requirements.

- b. Accept manifold flanges measuring 0.260 inch or more with no further rework required, if following criteria are met:

- (1) Ferrule hole depths are 0.145 inch or greater.
- (2) Flange surface finish is 32AA.

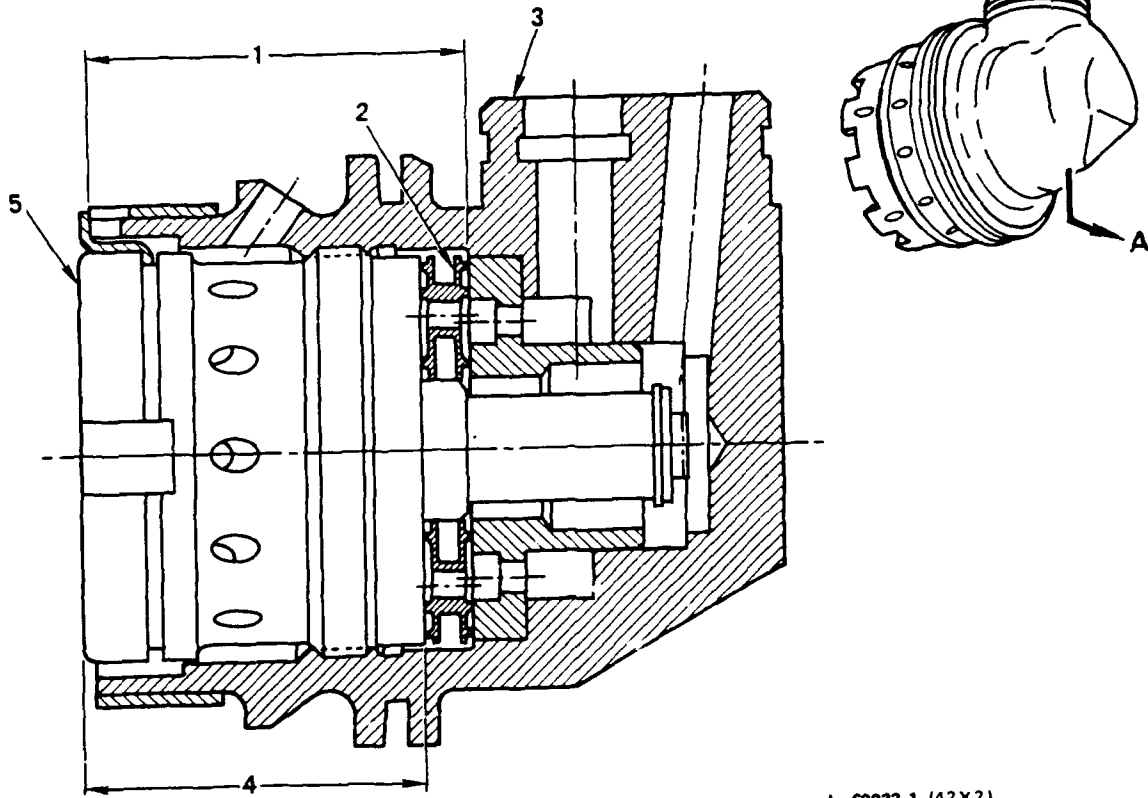
- c. Reject manifolds with flanges that do not measure up to 0.260 inch or with ferrule depths less than 0.145 inch.
- d. Pits, chips, or voids that extend from bushing sealing surface ID maximum of 0.015 inch wide and 0.015 inch deep are permissible when reworked to smooth contour (blend two times width/depth minimum). Refer to T.O. 2J-TF33-53-1, WP 013 00.



1. 0.260 inch minimum thickness at Location B

2. Location B

Figure 21. Fuel Manifold Inlet Flange Measurements



L-60932-1 (42 X 2)

Figure 23. Fuel Nozzle - Installation

"IN" DATES PROFILE

NAME _____ ALC <u>DC-ALC</u> DATE <u>5/10/87</u> RCC <u>MTACB</u> SHEET <u>1</u> OF <u>1</u>			
PCIH <u>98034A</u>			
PARENT WCD _____ PARENT WCD DATE _____			
OBSERVATION NUMBER	"IF" DATE (SCHEDULED DATE)	FIRST OPERATION (DATE)	Δ TIME (HRS)
1	8279	8279	0
2	8305	8308	72
3	8307	8308	24
4	8320	8322	48
5	8355	8355	0
6	9020	9023	72
7	9039	9041	48
8	9054	9054	0
9	9054	9055	24
10	9060	9061	24
			(32)

"OUT" DATES PROC. LE

NAME _____		ALC <u>OC-ALC</u>	DATE <u>31 MAY 89</u>	RCC <u>MT PCB</u>	SHEET <u>1</u> OF <u>1</u>
PCI	ISH	PHI	PARENT WCD	PARENT WCD DATE	
98034A					
OBSERVATION NUMBER	LAST OPERATION (COMPLETION DATE)	"OUT" DATE (SCHEDULED SELL DATE)	Hrs A TIME (DAYS)		
1	8297	8298	24		
2	8330	8333	72		
3	8323	8326	72		
4	8340	8340	0		
5	9006	9009	72		
6	9041	9041	0		
7	9059	9061	48		
8	9066	9066	0		
9	9069	9072	72		
10	9074	9074	0		
			(36)		

NOTE: "OUT" DATE IS THE DATE SCHEDULING PROCESSES THE ASSET FOR MOVEMENT FROM THE RCC.

OPERATION PROFILE

NAME <u>KOBYLK</u>		ALC <u>OC-ALC</u>		DATE <u>25 MAY 89</u>		RCC <u>MATCBE</u>		SHEET <u>1 OF 9</u>				
ITEM CODE <u>98042A</u>		WCD <u>CRECO4</u>		WCD DATE <u>89087</u>								
PIN <u>98042A</u>		MANDATORY OCCURRENCE FACTOR		OPERATION TYPE		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	QTY.	TIME REQUIRED %	HRS.
000	MAT CB	IN	1.0	TRANSIT								
				SETUP								
				PROCESS	0							
010	MAT PCB	REC	1.0	TRANSIT								
				SETUP								
				PROCESS		BPO9	1	100	.1	1	100	.1
040	CB	REM	1.0	TRANSIT								
				SETUP								
				PROCESS		BPO9	1	100	.05	1	100	.05
041	CB	WSP	1.0	TRANSIT								
				SETUP								
				PROCESS		BPO9	1	100	.05	1	100	.05
042	CB	TEST	.02	TRANSIT								
				SETUP								
				PROCESS	24							

80% OF MAN. RECEIVED FROM THE "BADA". 20% OF MAN. RECEIVED FROM ENGINE STOP. RECEIVE 25 AT A TIME FROM "DAZN".

AMIX OF ELECTRICITY MANIFOLDS RECEIVED FIRST PART OF WCD 010 REMOVE PART FROM SHIPPING FUTURE. CHECK FUTURE FOR DISTURBANCE.

WCD 040 INSPECT MANIFOLD FOR DISTURBANCE. IF MANIFOLDS HAVE NOT BEEN FULLED SEND TO (PCW) BLOC 3108.

WCD 0301035 NOW FULLED PART GO TO BLOC 3108 FOR STECOI TESTING. IF CHECKED 4AT THE MANIFOLDS ARE SOLD. TESTING STECOI MANIFOLD IS USED.

OPERATION PROFILE

NAME <u>KOBYLK</u>		ALC <u>OC-ALC</u>		DATE <u>25 MAY 89</u>		RCC <u>MATCBF</u>		SHEET <u>2</u> OF <u>9</u>						
ITEM CODE <u>PCN 78042A</u>		WCD <u>CREC04</u>		WCD DATE <u>89087</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	M-POWER		EQUIPMENT		DATA SOURCE COMMENTS				
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.		EQUIPMENT CODE	QTY.	TIME REQUIRED %	HRS.
043	CB	PROC	.98	TRANSIT	1.0	BPO9	1	100	.05	FENCE	1	100	.05	OIL PUT ON NOZZLES AND LEFT ON FOR ONE HOUR TO SATURATE THREADS FOR EASY REMOVAL.
				SETUP										
				PROCESS										
044	CB	REM	1.0	TRANSIT									REMOVE NOZZLES IF POSSIBLE. DISCARD OLD SEALS & LOCK TAPS	
				SETUP										
				PROCESS										
045	CB	INSP	1.0	TRANSIT		BPO9	1	100	.17	FENCE	1	100	.17	WCD 020 INSPECT PART FOR CRACKS, STRIPPED THREADS AND FROZEN NOZZLES
				SETUP										
				PROCESS										
046	CB	ID	1.0	TRANSIT		BPO9	1	100	.03	FENCE	1	100	.03	WCD 020 IDENTIFY PARTS AND ATTACH PART NUMBER
				SETUP										
				PROCESS										
047	CB	INSP	.2	TRANSIT		BPO9	1	100	.05	FENCE	1	100	.05	SECOND PART OF WCD 010 20% OF PARTS ARE BEING REPAIRED. THEY ARE RED TAGGED AND SCRAPPED.
				SETUP										
				PROCESS										
				PROCESS		BPO9	1	100	.08	FENCE	1	100	.08	

NAME <u>KOBYCK</u>		ALC <u>QC-ALC</u>		DATE <u>25 MAY 89</u>		RCC <u>MATCBE</u>		SHEET <u>3</u> OF <u>9</u>			
ITEM CODE		PCN <u>98042A</u>		WCD <u>CRECOY</u>		WCD DATE <u>89087</u>					
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.		
050	CB	CLN	1.0	TRANSIT							
				SETUP							
				PROCESS							
055	MT PIW	REM	1.0	TRANSIT							
				SETUP							
				PROCESS							
060	IW	INSP	1.0	TRANSIT							
				SETUP							
				PROCESS							
090	MT PCM	REP	1.0	TRANSIT							
				SETUP							
				PROCESS							
100	CM	REPL	1.0	TRANSIT							
				SETUP							
				PROCESS							

[illegible]

NAME		ALC		OC-ALS		DATE		25 MAY 89		RCC		MATCBF		SHEET 5 OF 9	
ITEM CODE		PCN		HBN		WCD		CRECOY		WCD DATE		89087			
OPERATION NUMBER		RCC		OPERATION DESCRIPTION		MANDATORY OCCURRENCE FACTOR		OPERATION TYPE		MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT	
												SKILL CODE/LEVEL		QTY.	
												TIME REQUIRED %		TIME REQUIRED HRS.	
												QTY.		HRS.	
150	MT PIW			INS P	1.0			TRANSIT							
				SETUP											
				PROCESS											
155	MT PCM			PROC	1.0			TRANSIT							
								SETUP							
								PROCESS							
160	CM			PROC	1.0			TRANSIT							
								SETUP							
								PROCESS		120					
165	MAT PCB			INS P	1.0			TRANSIT							
								SETUP	BPO9	1	100	.01	FENES	1	100
								PROCESS	BPO9	1		.24	PUNEE	1	.01
170	CB			TEST	1.0			TRANSIT							
								SETUP							
								PROCESS							

NAME <u>KOBYLK</u>		ALC <u>OC-ALC</u>		DATE <u>25 MAY 89</u>		RCC <u>MATCBE</u>		SHEET <u>6 OF 9</u>	
ITEM CODE		PCN <u>98042A</u>		WCD <u>98042A</u>		WCD DATE <u>98087</u>			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.
210	MT PCM	PROC	1.0	TRANSIT					
				SETUP					
				PROCESS					
215	MT PIW	CLN	1.0	TRANSIT					
				SETUP					
				PROCESS					
220	IW	PROC	1.0	TRANSIT					
				SETUP					
				PROCESS					
230	IW	PROC	1.0	TRANSIT					
				SETUP					
				PROCESS	16				
250	MT CB	INSP	1.0	TRANSIT					
				SETUP					
				PROCESS					

NAME		KOBLYK		ALC OC-ALC		DATE 25 MAY 89		RCC MATCBF		SHEET 7 OF 9	
ITEM CODE		PCN 98034A 98042A		WCD CRECOY		WCD DATE 89087					
OPERATION NUMBER		RCC		OPERATION DESCRIPTION		MANDATORY OCCURRENCE FACTOR		OPERATION TYPE		MANPOWER	
										EQUIPMENT	
										TIME REQUIRED	
										% HRS.	
										QTY.	
										SKILL CODE/LEVEL	
										TIME REQUIRED	
										% HRS.	
										DATA SOURCE COMMENTS	
260	CB	PROC	1.0	TRANSIT							
				SETUP							BODY SEATS ARE LAPPED BY HAND
				PROCESS							
270	CB	CLN	1.0	TRANSIT							
				SETUP							
				PROCESS							PART IS FLUSHED AND AIR DRIED
280	CB	PROC	1.0	TRANSIT							
				SETUP							
				PROCESS							MEASURE NOZZLE AND BODY HOUSING DEPTH. SUBTRACT ONE FROM THE OTHER TO DETERMINE WHAT SIZE SEAL IS REQUIRED
290	CB	ASSY	1.0	TRANSIT							
				SETUP							
				PROCESS							
330	CB	INT	1.0	TRANSIT							
				SETUP							
				PROCESS							INSTALL CAPS ON NOZZLES

NAME <u>K03YLK</u>		ALC <u>OC-ALC</u>		DATE <u>25 MAY 89</u>		RCC <u>MATCBF</u>		SHEET <u>8</u> OF <u>9</u>							
ITEM CODE <u>PCN 780317A</u>		NON <u>98012A</u>		WCD <u>CRECOY</u>		WCD DATE <u>89087</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT	DATA SOURCE COMMENTS
340	CB	PW	1.0	TRANSIT											IDENTIFY PROCESS PAPERWORK
				SETUP											
				PROCESS											
350	CB	TEST	1.0	TRANSIT		BPO9	1	100	.09		1	100	.09		WCD 320+340 CONVEYER TO BLOC 3108 FOR TESTING #WCDCTECO AND RETURNED BY CONVEYER
				SETUP											
				PROCESS	16										
370	CB	PROC	1.0	TRANSIT										WCD 350 TIGHTEN SEALS, SET TAB LOCKS, PERFORM DISTO CHECK BY VISUAL AND FEEL	
				SETUP											
				PROCESS											
380	MTB CM	PROC	1.0	TRANSIT		BPO9	1	100	.4		1	100	.4	WCD 370+390 - REMOVE CAPS AND HAND LAP TO A FINE FINISH.	
				SETUP											
				PROCESS	.25										
400	MAT CB	LOAD	1.0	TRANSIT										WCD 380 - CAP PART AND BOLT TO FIXTURE FINE	
				SETUP											
				PROCESS											
						BPO9	1	100	.15		1	100	.15		WCD 400

DEFINITION

OPERATION PROFILE

NAME <u>KoBYLK</u>		ALC <u>OC-ALC</u>		DATE <u>25 MAY 89</u>		RCC <u>INATCB</u>		SHEET <u>9</u> OF <u>9</u>					
PCN <u>98034</u>		WCD <u>CRESOL</u>		WCD DATE <u>89087</u>									
ITEM CODE <u>98042A</u>		PIN <u>98057A</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	%	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.		%
410	CB	PW	1.0	TRANSIT									INSURE FRAMED ID. COMPLETE APTD 349, COMPLY WITH MIAOT 66-36 PAR 413.
				SETUP									
				PROCESS									
430	CB	INSP	1.0	TRANSIT									WCD 410, 420 + 435 INSPECT
				SETUP									
				PROCESS									
432	CB	PW	1.0	TRANSIT									WCD 430 TAG & PROCESS PAPERWORK.
				SETUP									
				PROCESS									
440	CB	MOVE	1.0	TRANSIT									WCD 430 MOVE TO PICK-UP STATION
				SETUP									
				PROCESS									
9999	MAT CB	OUT	1.0	TRANSIT									WCD 440
				SETUP									
				PROCESS									

FLOW PROCESS CHART

SUBJECT TF33 MANIFOLDS LEFTSIDE

DATE 26 MAY 99

ITEM CODE

WCD CRFC04

WCD DATE 80087

PCN

NBN

FIN

98034A (PT) 98043A
98042A (PT) 98057A

CHART BEGINS

IN

CHART ENDS

9999

PREPARED BY S. KOB/LK

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○●□□▽	RECEIVE + MOVE TO TESTING ST.	290	290	●□□□▽	ASSEMBLE
040	040	●□□□▽	REMOVE EXHAUST BENDING EXHAUST	330	330	●□□□▽	INSTALL CAPS
041	030	○□□□▽	DISTORTION CHECK	340	340	●□□□▽	PAPER WORK
—	235	○□□□▽	CRITICAL THICKNESS	—	320	●□□□▽	IDENTIFY PART
042	—	○□□□▽	NON-FLAME PARTS SENT TO TEST	350	350	●□□□▽	TEST PART
043	—	●□□□▽	OIL NOZZLES	370	370	●□□□▽	TIGHTEN SLEEVES
044	020	●□□□▽	REMOVE NOZZLES	—	390	○□□□▽	CHECK PART
045	020	○□□□▽	INSPECT PARTS	380	380	●□□□▽	REMOVE CAPS LAP PART
046	010	●□□□▽	IDENTIFY ATTACH PW	400	400	●□□□▽	CAP PART + BOLT TO EXHAUST
047	—	○□□□▽	NO TAG ISAL PARTS	410	410	●□□□▽	CHECK ID
050	050	●□□□▽	CLEAN PARTS	—	420	●□□□▽	PAPER WORK
055	055	●□□□▽	REMOVE HEATSHIELDS	—	435	●□□□▽	CHECK COMPLIANCE
060	060	○□□□▽	INSPECT PARTS	440	440	○□□□▽	PICK UP STATION
070	070	●□□□▽	REPAIR NOZZLES			○□□□▽	
100	100	●□□□▽	REMOVE/REPLACE SLEEVES			○□□□▽	
110	110	○□□□▽	INSPECT LUGS			○□□□▽	
140	140	●□□□▽	REPAIR LUGS			○□□□▽	
142	142	●□□□▽	MACHINE LUGS			○□□□▽	
145	145	●□□□▽	REPAIR INLET			○□□□▽	
150	150	○□□□▽	INSPECT PARTS			○□□□▽	
155	155	●□□□▽	PERFORM MOD.			○□□□▽	
160	160	●□□□▽	DISTORTION CHECK BEND STRAIGHT			○□□□▽	
165	160	○□□□▽	INSPECT PARTS			○□□□▽	
—	165	●□□□▽	INSPECT HEAT- SHIELD + LOCKWIRE			○□□□▽	
170	170	●□□□▽	TEST			○□□□▽	
210	210	●□□□▽	DRILL HOLES			○□□□▽	
215	215	●□□□▽	FLUSH PART			○□□□▽	
220	220	●□□□▽	INJECT SILICON			○□□□▽	
230	230	●□□□▽	BAKE PART			○□□□▽	
260	260	●□□□▽	LAP SEATS			○□□□▽	
270	270	●□□□▽	CLEAN PART			○□□□▽	
280	280	●□□□▽	MEASURE NOZZLE			○□□□▽	

○ OPERATION

▽ STORAGE

□ INSPECTION

◇ TRANSPORTATION

D DELAY

LSC-20147

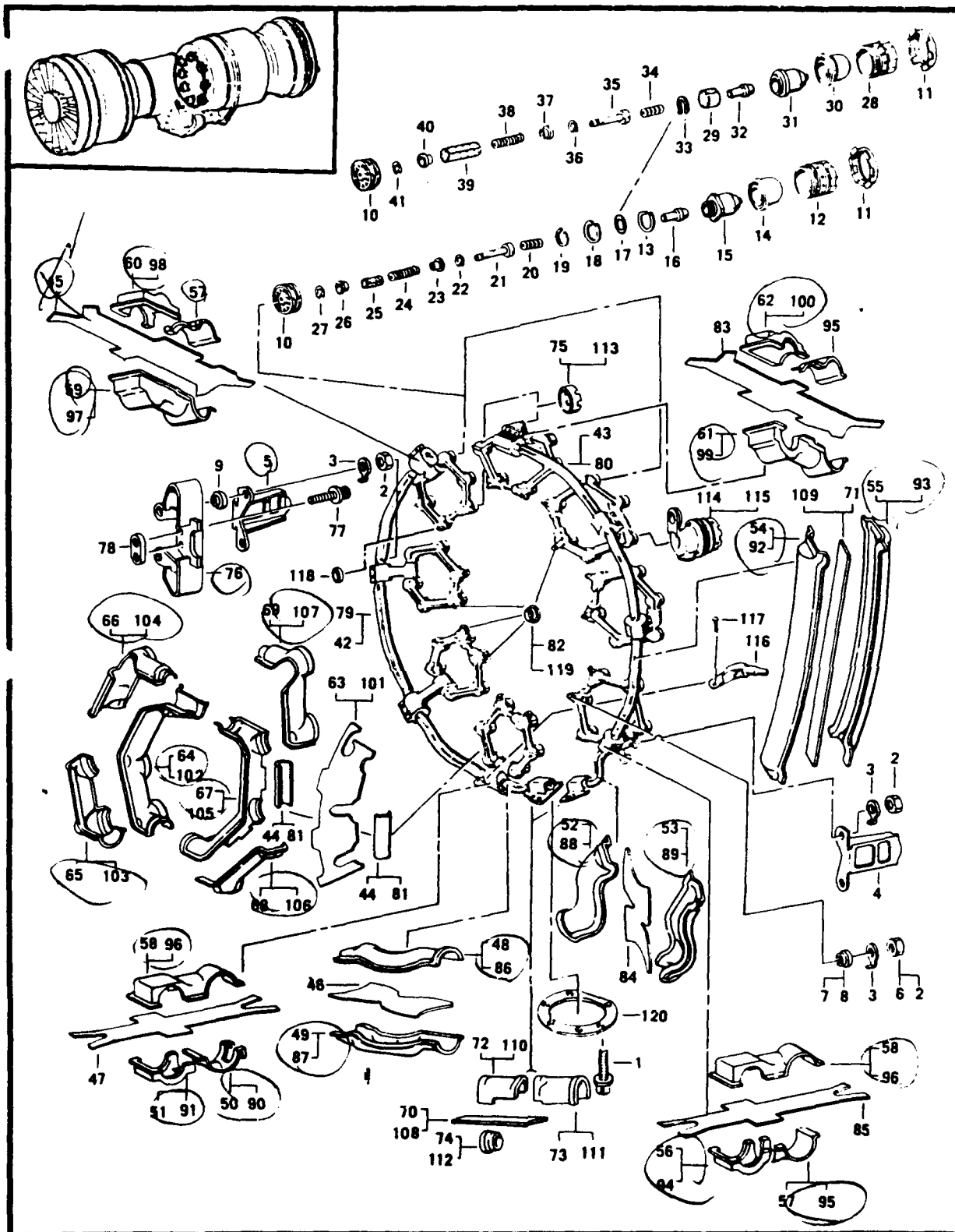


FIGURE 27 - MANIFOLDS-FUEL. NOZZLES-FUEL.

PCN 98034A 98043A
 98042A 98057A

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SM
26 - 63	410935	52661		RING-SPL, RTNG 0.938 HSG DIA X 0.075 WALL X 0.042 IN. THK	1		PAFBZN
- 64	742372	52051		GEARSHAFT-BEVEL, MAIN DRIVE GRBX SHAFT	1		PAFFFFP
- 65	770329	52661		BEARING OPTION-REF NO. ONLY ORDER ONE OF THE FOLLOWING	1		XC----
	741415	52661		BEARING-RLR, CYL 1.4949 X 3.3999 X 0.952, OPTL TO 741416			PAFBZN
	741416	52661		BEARING-RLR, CYL 1.4949 X 3.3999 X 0.952, OPTL TO 741415			PAFBZN
- 66	742366	52661		SPACER-RING 1.500 ID X 1.860 OD X 0.080 IN. THK	1		PAFZZN
- 67	742365	52661		SPACER-BRG ACCESS DRIVE GRSHFT	1		PAFZZN
	801659	52661		BEARING ASSEMBLY-GRBX DRIVE SUPERSEDES 742369	1		XB----
- 68	742368	52661		HOUSING-GRBX DRIVE BRG	1		PAFBZN
- 69	802862	52661		BEARING OPTION-REF NO. ONLY ORDER THE FOLLOWING SUPERSEDES 488748 OPTION C/O 488747 OR 770612 PRCMT NO. C/O	1		XC----
	798868	52661		BEARING-BALL 35 MM X 72 MM X 17 MM, OPTL TO 798869			PAFBZN
	798869	52661		BEARING-BALL 35 MM X 72 MM X 17 MM, OPTL TO 798868			
- 70	749920	52661		SPACER ASSEMBLY-GRBX DRIVE BRG	1		PAFZZN
- 71	MS9390-080	96906		.PIN	1		PADZZN
- 72	742378	52661		HOUSING-ASSY OF, GRBX DRIVE BRG	1		PAFBZN

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R
R

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27	483266	52661		MANIFOLDS-FUEL. NOZZLES-FUEL.			
- 1	524342	52661		MANIFOLD SET-FUEL	1	AS	XB----
	237233	52661		MANIFOLD SET-FUEL	1	B/AT	XB----
- 2	MS9356-10	96906		BOLT-MACH. DRILLED DBL HEX	6		PAFZZN
				0.3125-24 X 0.500 IN. LONG (AP)			
	MS9356-10	96906		NUT (AP)	32	AS	PAFZZN
				SUPERSEDES AN121527			
				FOR A ENG			
	MS9356-10	96906		NUT (AP)	16	AT	PAFZZN
				SUPERSEDES AN121527			
				FOR A ENG			
- 3	227340	52661		WASHER-KEY 0.2575 ID X 0.055 (AP)	32		PAFZZN
- 4	435348	52661		BRACKET-COMB CHMBR (AP)	2		PAFZZN
- 5	454391	52661		BRACKET-COMB CHMBR FR (AP)	6		PAFZZN
- 6	MS9357-10	96906		NUT (AP)	16	B/AT	PAFZZN
				SUPERSEDES 328835			
				FOR A ENG			
- 7	524325	52661		LOCK-FUEL MANF (AP)	16	B/AT	PAFZZN
- 8	490029	52661		LOCK-FUEL NOZ HSG (AP)	16	AS	PAFZZN
- 9	483263	52661		BUSHING-SLV 0.260 X 0.440 X 0.459.	12		PAFZZN
				FLG (AP)			
	483268	52661		MANIFOLD AND NOZZLE-ASSY OF, FUEL.	1	AS	PAFDDT
				RIGHT, PREFERRED U/W			
				483266 MANF SET			
	483267	52661		MANIFOLD AND NOZZLE-ASSY OF, FUEL.	1	AS	PAFDDT
				LEFT, PREFERRED U/W			
				483266 MANF SET			
	563217	52661		MANIFOLD AND NOZZLE-ASSY OF, FUEL.	1	B/AT	PAFDDT
				RIGHT, PREFERRED U/W			
				524342 MANF SET			
				SUPERSEDES 524341			
	563215	52661		MANIFOLD AND NOZZLE-ASSY OF, FUEL.	1	B/AT	PAFDDT
				LEFT, PREFERRED U/W			
				524342 MANF SET			
				SUPERSEDES 524340			
- 10	218406	52661		SEAL-FUEL NOZ, ALSO REQD FOR SVCE ...	24		PAFZZN
				REPAIR OF FUEL MANF AND NOZ			
				ASSY			
	749885	52661		SEAL-FUEL NOZ, ALSO REQD FOR SVCE ...	24		PAFZZN
				REPAIR OF FUEL MANF AND NOZ			
				ASSY			
- 11	431839	52661		WASHER-KEY, FUEL NOZ	24		PAFZZN
	157872	52661		TABWASHER-FUEL NOZ, AIR FORCE	48		
				ASSIGNED APPLICATION			
	481694	52661		NOZZLE ASSEMBLY-FUEL, REPAIR KIT	24	AU	PAFDDT
				500072 AVAILABLE			
- 12	484454	52661		NUT-FUEL NOZ	1	AU	PAFZZN
	484455	52661		NOZZLE SET-FUEL	1	AU	ADD---
- 13	287829	52661		RING-RTNG 0.750 OD X 0.040 WIDE	1	AU	KD---
				X 0.0165 IN. THK			
- 14	739595	52661		NOZZLE-FUEL	1	AU	PADBZN
- 15	739596	52661		NOZZLE-FUEL	1	AU	PADBZN
- 16	739597	52661		METERING PLUG-NOZZLE	1	AU	PADBZN
- 17	484452	52661		STRAINER ELEMENT-SCREEN 0.495	1	AU	KD---
				CONTINUED			

FIGURE INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27				ID X 0.756 OD X 0.00375 IN. THK			
- 18	267630	52661	...	RING-RTNG 0.813 OD X 0.040 WIDE X 0.0165 IN. THK	1	AU	KD----
- 19	267631	52661	...	RING-RTNG 0.453 OD X 0.040 WIDE X 0.0165 IN. THK	1	AU	KD----
- 20	267627	52661	...	SPRING-HLCPS 0.213 OD X 0.036 IN. DIA WIRE	1	AU	PADZZN
- 21	267626	52661	...	SUPPORT-FUEL NOZ	1	AU	PADZZN
- 22	267632	52661	...	RING-RTNG 0.312 HSG DIA X 0.015 IN. THK	1	AU	KD----
- 23	267624	52661	...	FLANGE-FUEL NOZ	1	AU	PADZZN
- 24	368448	52661	...	SPRING-HLCPS 0.246 OD X 0.159 IN. DIA WIRE	1	AU	PADZZN
- 25	484453	52661	...	STRAINER ELEMENT-SLV 0.255 X 0.424 IN. LONG	1	AU	PADZZN
- 26	267625	52661	...	FLANGE-FUEL NOZ	1	AU	PADZZN
- 27	267623	52661	...	RING-RTNG 0.156 SHAFT DIA X 0.025 IN. THK	1	AU	KD----
	500072	52661	...	PARTS KIT-REPAIR. FOR REPAIR OF 481694 FUEL NOZ	1	AU	
	663430	52661	...	NOZZLE ASSEMBLY-FUEL. REPAIR KIT 546104 AVAILABLE SUPERSEDES 518126	24	B/AV	PAFDDT
- 28	663429	52661	...	NUT-FUEL NOZ SUPERSEDES 484454	1	B/AV	PAFZZN
	520202	52661	...	NOZZLE ASSEMBLY-FUEL	1	B/AV	ADD---
	749743	52661	...	NOZZLE SET-FUEL	1	B/AV	ADD---
- 29	539512	52661	...	STRAINER ELEMENT-SLV 0.4881	1	B/AV	PADZZN
- 30	739598	52661	...	NOZZLE-FUEL	1	B/AV	PADBZN
- 31	739599	52661	...	NOZZLE-FUEL	1	B/AV	PADBZN
- 32	739597	52661	...	METERING PLUG-FUEL NOZ	1	B/AV	PADBZN
- 33	520205	52661	...	RING-RTNG 0.750 HSG DIA X 0.035 IN. THK	1	B/AV	PADZZN
- 34	267627	52661	...	SPRING-HLCPS 0.213 OD X 0.036 IN. DIA WIRE	1	B/AV	PADZZN
- 35	267626	52661	...	SUPPORT-FUEL NOZ	1	B/AV	PADZZN
- 36	520204	52661	...	RING-RTNG. FUEL NOZ	1	B/AV	PADZZN
- 37	267624	52661	...	FLANGE-FUEL NOZ	1	B/AV	PADZZN
- 38	368448	52661	...	SPRING-HLCPS 0.246 OD X 0.159 IN. DIA WIRE	1	B/AV	PADZZN
- 39	484453	52661	...	STRAINER ELEMENT-SLV 0.255 X 0.424	1	B/AV	PADZZN
- 40	267625	52661	...	FLANGE-FUEL NOZ	1	B/AV	PADZZN
- 41	520203	52661	...	RING-RTNG. FUEL NOZ	1	B/AV	PADZZN
	546104	52661	...	PARTS KIT-REPAIR. FOR REPAIR OF 518126 AND 663430 FUEL NOZ ASSY	1	B/AV	PADZZN
- 42	483264	52661	...	MANIFOLD-ASSY OF, FUEL, RIGHT	1	AS	XA----
- 43	483265	52661	...	MANIFOLD-ASSY OF, FUEL, LEFT	1	AS	XA----
- 44	348838	52661	...	SLEEVE HALF-REINFORCING, TUBE	32	AS	PADZZN
- 45	531386	52661	...	INSULATION BLANKET-FUEL MANF SUPERSEDES 336534 FOR A ENG	1	AS	XB----
- 46	531388	52661	...	INSULATION BLANKET-FUEL MANF SUPERSEDES 219224 FOR A ENG	1	AS	XB----
				CONTINUED			

T.O. 2J-TF33-44

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27 - 86	358279	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 87	358280	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 88	358203	52661	SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
- 89	358202	52661	SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
- 90	358289	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 91	358291	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 92	358288	52661	SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 93	358287	52661	SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 94	358293	52661	SHIELD-HEAT, LEFT FUEL MANF	3	B/AT	PADZZN
	358293	52661	SHIELD-HEAT, RIGHT FUEL MANF	2	B/AT	PADZZN
- 95	358292	52661	SHIELD-HEAT, LEFT FUEL MANF	4	B/AT	PADZZN
	358292	52661	SHIELD-HEAT, RIGHT FUEL MANF	3	B/AT	PADZZN
- 96	358290	52661	SHIELD-HEAT, FUEL MANF	3	B/AT	PADZZN
- 97	358295	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 98	358294	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
- 99	358206	52661	SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
-100	358205	52661	SHIELD-HEAT, LEFT FUEL MANF	1	B/AT	PADZZN
-101	531384	52661	INSULATION BLANKET-FUEL MANF	8	B/AT	XB----
-102	375060	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-103	358286	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-104	375059	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-105	375057	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-106	358281	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-107	375058	52661	SHIELD-HEAT, FUEL MANF	4	B/AT	PADZZN
-108	531389	52661	INSULATION BLANKET-FUEL MANF	1	B/AT	XB---
-109	531387	52661	INSULATION BLANKET-FUEL MANF	3	B/AT	XB----
-110	358278	52661	SHIELD-HEAT, RIGHT FUEL MANF	1	B/AT	PADZZN
-111	358204	52661	SHIELD-HEAT, LEFT MANF	1	B/AT	PADZZN
-112	261803	52661	FERRULE-FUEL MANF	1	B/AT	PADZZN
-113	483776	52661	SLEEVE-FUEL NOZ	24	B/AT	PADZZN
-114	674002	52661	..	HOUSING-ASSY OF, SVCE FIX FOR	1		
				REWK OF FUEL NOZ ASSY			
-115	674003	52661	..	HOUSING-ASSY OF, SVCE FIX FOR	1		
				REWK OF FUEL NOZ ASSY			
-116	253759	52661	..	PROBE-PB, RIGHT FUEL MANF	1		PAFZZN
-117	AN123176	81352	..	RIVET-RIGHT FUEL MANF	1		PAFZZN
-118	515359	52661	..	SPACER-RING 0.551 X 0.755 X	8		
				0.135, SVCE FIX FOR REWK OF			
				483264 OR 483265 FUEL MANF			
				ASSY			
-119	524324	52661	..	WASHER-SHLDR 0.535 X 0.750, SVCE	16		PADZZN
				FIX FOR REWK OF 483264 OR			
				483265 FUEL MANF ASSY			
-120	457128	52661	G	ASKET-FUEL MANF INLET ADPTR	1		PAFZZN

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	1 2 3 4 5 6 7	DESCRIPTION	UNITS PER ASSY	USABLE ON CODE	SMR
27				SUPERSEDES 511714 FOR A ENG			
- 47	531385	52661	...	INSULATION BLANKET-FUEL MANF	3	AS	XB----
				SUPERSEDES 336535 FOR A ENG			
- 48	358279	52661	...	SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 49	358280	52661	...	SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 50	358289	52661	...	SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 51	358291	52661	...	SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 52	358203	52661	...	SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 53	358202	52661	...	SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 54	358288	52661	...	SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 55	358287	52661	...	SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 56	358293	52661	...	SHIELD-HEAT, LEFT FUEL MANF	3	AS	PADZZN
	358293	52661	...	SHIELD-HEAT, RIGHT FUEL MANF	2	AS	PADZZN
- 57	358292	52661	...	SHIELD-HEAT, LEFT FUEL MANF	4	AS	PADZZN
	358292	52661	...	SHIELD-HEAT, RIGHT FUEL MANF	3	AS	PADZZN
- 58	358290	52661	...	SHIELD-HEAT, FUEL MANF	3	AS	PADZZN
- 59	358295	52661	...	SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 60	358294	52661	...	SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 61	358206	52661	...	SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 62	358205	52661	...	SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 63	531384	52661	...	INSULATION BLANKET-FUEL MANF	8	AS	XB----
				SUPERSEDES 253818			
- 64	375060	52661	...	SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 65	358286	52661	...	SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 66	375059	52661	...	SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 67	375057	52661	...	SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 68	358281	52661	...	SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 69	375058	52661	...	SHIELD-HEAT, FUEL MANF	4	AS	PADZZN
- 70	531389	52661	...	INSULATION BLANKET-FUEL MANF	1	AS	XB----
				SUPERSEDES 253819 FOR A ENG			
- 71	531387	52661	...	INSULATION BLANKET-FUEL MANF	3	AS	XB----
- 72	358278	52661	...	SHIELD-HEAT, RIGHT FUEL MANF	1	AS	PADZZN
- 73	358204	52661	...	SHIELD-HEAT, LEFT FUEL MANF	1	AS	PADZZN
- 74	261803	52661	...	FERRULE-FUEL MANF	1	AS	PADZZN
- 75	483776	52661	...	SLEEVE-FUEL NOZ	24	AS	PADZZN
	563218	52661	...	BRACKET AND MANIFOLD-ASSY OF,	1	B/AT	XA----
				FUEL, RIGHT			
				SUPERSEDES 525041			
	563216	52661	...	BRACKET AND MANIFOLD-ASSY OF,	1	B/AT	XA----
				FUEL, LEFT			
				SUPERSEDES 525041			
- 76	483260	52661	...	BRACKET-ASSY OF, FUEL MANF	3	B/AT	PAFBZN
- 77	303328	52661	...	BOLT-MACH, DRILLED DBL HEX	6	B/AT	PAFZZN
				0.250-28 X 0.625 IN. LONG			
- 78	454393	52661	...	NUT-PLAIN, MULTIPLE 0.250-28	3	B/AT	PAFZZN
				X 0.560 IN. LONG			
- 79	525041	52661	...	MANIFOLD-ASSY OF, FUEL, RIGHT	1	B/AT	XA----
- 80	525040	52661	...	MANIFOLD-ASSY OF, FUEL, LEFT	1	B/AT	XA----
- 81	348838	52661	...	SLEEVE HALF-REINFORCING TUBE	32	B/AT	PADZZN
- 82	524324	52661	...	WASHER-SHLDR 0.535 X 0.750	16	B/AT	PADZZN
- 83	531386	52661	...	INSULATION BLANKET-FUEL MANF	1	B/AT	XB----
- 84	531388	52661	...	INSULATION BLANKET-FUEL MANF	1	B/AT	XB----
- 85	531385	52661	...	INSULATION BLANKET-FUEL MANF	3	B/AT	XB----

DISASSEMBLY/ASSEMBLY ...FILE

NAME <u>PHUNT</u>		ALC <u>QC</u>		DATE <u>6-16-89</u>		ROC <u>MATPCB</u>		SHEET <u>1</u> OF <u>5</u>	
TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			NAME OF MOVED ITEM INSTALLED WITH LAST TIN	
ITEM NUMBER	WCD	WCD DATE			ITEM NUMBER	CHRD WCD	CHRD WCD DATE		
PCN 98034A 98043A NSH 98042A 78057A PIN	CBEC04	88097	55	290	PCN 358279 NSH PIN	98034A 98043A 98042A 78057A S1			
PCN NSH PIN					PCN 35820 NSH PIN	52			
PCN NSH PIN					PCN 35829 NSH PIN	53			
PCN NSH PIN					PCN 358291 NSH PIN	54			
PCN NSH PIN					PCN 358203 NSH PIN	55			
PCN NSH PIN					PCN 358202 NSH PIN	56			
PCN NSH PIN					PCN 358288 NSH PIN	57			
PCN NSH PIN					PCN 358287 NSH PIN	58			
PCN NSH PIN					PCN 358293 NSH PIN	59			
PCN NSH PIN					PCN 358293 NSH PIN	510			
PCN NSH PIN					PCN 358292 NSH PIN	511			
PCN NSH PIN					PCN 358292 NSH PIN	512			

DISASSEMBLY/ASSEMBLY ... FILE

NAME <u>PHUNT</u>		AIC <u>OC</u>		DATE <u>6-16-87</u>		NCC <u>MAPCB</u>		SHEET <u>2 of 5</u>	
TOP ASSEMBLY				SUBASSEMBLY		REMOVAL OPERATION NUMBER		INSTALLATION OPERATION NUMBER	
ITEM NUMBER	WCB	WCD DATE	ITEM NUMBER	WCD DATE	REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	ITEM NUMBER	WCD DATE	REMOVAL OPERATION NUMBER
PCN 98034A 98043A NSH PIN 98042A 98057A	CBEC04	88097	PCN 358290 NSH PIN	98634A 98043A 98042A 98057A	55	290	PCN 358295 NSH PIN	514	
PCN NSH PIN			PCN 358294 NSH PIN				PCN 358295 NSH PIN	514	
PCN NSH PIN			PCN 358206 NSH PIN				PCN 358294 NSH PIN	515	
PCN NSH PIN			PCN 358205 NSH PIN				PCN 358206 NSH PIN	516	
PCN NSH PIN			PCN 375060 NSH PIN				PCN 358205 NSH PIN	517	
PCN NSH PIN			PCN 358286 NSH PIN				PCN 375060 NSH PIN	518	
PCN NSH PIN			PCN 375059 NSH PIN				PCN 358286 NSH PIN	519	
PCN NSH PIN			PCN 375057 NSH PIN				PCN 375059 NSH PIN	520	
PCN NSH PIN			PCN 358281 NSH PIN				PCN 375057 NSH PIN	521	
PCN NSH PIN			PCN 375058 NSH PIN				PCN 358281 NSH PIN	522	
PCN NSH PIN			PCN 358278 NSH PIN				PCN 375058 NSH PIN	523	
PCN NSH PIN							PCN 358278 NSH PIN	524	

DISASSEMBLY/ASSEMBLY ... FILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>6-16-87</u>		ROC <u>MA7PCB</u>		SHEET <u>3</u> OF <u>5</u>	
TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			LAME REMOVED ITEM INSTALLED MTO ASST VIN	
ITEM NUMBER	WCO	WCD DATE			ITEM NUMBER	CHLD WCD	CHLD WCD DATE		
PCN 98034A 98043A NSN PIN	CBEC04	88097	55	290	PCN NSN PIN	358204	98034A 98043A 98042A 98057A 525		
PCN NSN PIN					PCN NSN PIN	483226 52667	526		
PCN NSN PIN					PCN NSN PIN	563216 52667	527		
PCN NSN PIN					PCN NSN PIN	483260	528		
PCN NSN PIN					PCN NSN PIN	525041	529		
PCN NSN PIN					PCN NSN PIN	525040	530		
PCN NSN PIN					PCN NSN PIN	358229	531		
PCN NSN PIN					PCN NSN PIN	358280	532		
PCN NSN PIN					PCN NSN PIN	358203	533		
PCN NSN PIN					PCN NSN PIN	35802	534		
PCN NSN PIN					PCN NSN PIN	358289	535		
PCN NSN PIN					PCN NSN PIN	358291	536		

DISASSEMBLY/ASSEMBLY ... FILE

NAME <u>PHUNT</u>		ALC <u>OC</u>		DATE <u>6-16-89</u>		ROC <u>MATPCB</u>		SHEET <u>4</u> OF <u>6</u>	
TOP ASSEMBLY			REMOVAL OPERATION NUMBER	INSTALLATION OPERATION NUMBER	SUBASSEMBLY			NAME OF MOVED ITEM INSTALLED INTO ASST. TIN	
ITEM NUMBER	WCB	WCD DATE			ITEM NUMBER	CHLD WCD	CHLD WCD DATE		
PCB 98034A 98043A NSM PIN	CB6C04	88097	55	290	PCB NSM PIN	358288	98034A 98043A 98042A 98057A		
PCB NSM PIN					PCB NSM PIN	358287			
PCB NSM PIN					PCB NSM PIN	358293			
PCB NSM PIN					PCB NSM PIN	358293			
PCB NSM PIN					PCB NSM PIN	358292			
PCB NSM PIN					PCB NSM PIN	358290			
PCB NSM PIN					PCB NSM PIN	358295			
PCB NSM PIN					PCB NSM PIN	358294			
PCB NSM PIN					PCB NSM PIN	358206			
PCB NSM PIN					PCB NSM PIN	358205			
PCB NSM PIN					PCB NSM PIN	375060			
PCB NSM PIN					PCB NSM PIN	358286			

DISASSEMBLY/ASSEMBLY ...JFILE

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